

SECTION 051200

STRUCTURAL STEEL FRAMING

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section Includes:
 - 1. Structural steel.
 - 2. Architecturally exposed structural steel.
 - 3. Grout.
- B. Related Sections:
 - 1. Division 01 Section "Structural Testing and Special Inspection Services" for Fabricator's Certificate of Compliance and quality control.
 - 2. Division 05 Section "Architecturally Exposed Structural Steel Framing" for additional requirements for architecturally exposed structural steel.
 - 3. Division 05 Section "Steel Decking" for field installation of shear connectors through deck.
 - 4. Division 05 Section "Metal Fabrications" for miscellaneous steel fabrications and other metal items not defined as structural steel.
 - 5. Division 05 Section "Metal Stairs."
 - 6. Division 09 painting Sections for surface-preparation, priming and shop painting requirements.

1.3 DEFINITIONS

- A. Structural Steel: Elements of structural-steel frame, as classified by AISC 303, "Code of Standard Practice for Steel Buildings and Bridges."
- B. Architecturally Exposed Structural Steel: Structural steel designated as architecturally exposed structural steel (AESS) in the Contract Documents.
- C. Seismic-Load-Resisting System: Elements of structural-steel frame designated as "SLRS" or along grid lines designated as "SLRS" on Drawings, including columns, beams, and braces and their connections.
- D. Heavy Sections: Rolled and built-up sections as follows:
 - 1. Shapes included in ASTM A 6/A 6M with flanges thicker than 1-1/2 inches.
 - 2. Welded built-up members with plates thicker than 2 inches.
 - 3. Column base plates thicker than 2 inches.
- E. Protected Zone: Structural members or portions of structural members indicated as "Protected Zone" on Drawings. Connections of structural and nonstructural elements to protected zones are limited.
- F. Demand Critical Welds: Those welds, the failure of which would result in significant degradation of the strength and stiffness of the Seismic-Load-Resisting System and which are indicated as "Demand Critical" or "Seismic Critical" on Drawings.

1.4 PERFORMANCE REQUIREMENTS

- A. Connections: Provide details of connections required by the Contract Documents to be selected or completed by structural-steel fabricator, including comprehensive engineering design by a qualified professional engineer licensed in the project state, to withstand loads indicated and comply with other information and restrictions indicated.
 - 1. Select and complete connections using schematic details indicated and AISC 360, "Specification for Structural Steel Buildings."
 - 2. Use LRFD; data are given at factored-load level.
- B. Moment Connections: Type FR, fully restrained.
- C. Construction: Braced frame.

1.5 SUBMITTALS

- A. Product Data: For each type of product indicated.
- B. Shop Drawings: Show fabrication of structural-steel components.
 - 1. Include details of cuts, connections, splices, camber, holes, and other pertinent data.
 - 2. Include embedment drawings.
 - 3. Indicate welds by standard AWS symbols, distinguishing between shop and field welds, and show size, length, and type of each weld. Show backing bars that are to be removed and supplemental fillet welds where backing bars are to remain.
 - 4. Indicate type, size, and length of bolts, distinguishing between shop and field bolts. Identify pretensioned and slip-critical high-strength bolted connections.
 - 5. Identify members and connections of the seismic-load-resisting system.
 - 6. Indicate locations and dimensions of protected zones.
 - 7. Identify demand critical welds.
 - 8. For structural-steel connections indicated to comply with design loads, include structural design data signed and sealed by the qualified professional engineer responsible for their preparation and licensed in the project state.
 - 9. Clearly indicate which members and connections are considered as AECS.
- C. Welding Procedure Specifications (WPSs) and Procedure Qualification Records (PQRs): Provide according to AWS D1.1/D1.1M, "Structural Welding Code - Steel," for each welded joint whether prequalified or qualified by testing, including the following:
 - 1. Power source (constant current or constant voltage).
 - 2. Electrode manufacturer and trade name, for demand critical welds.
- D. Qualification Data: For qualified professional engineer, installer and fabricator, including copies of fabricator's AISC Certification.
- E. Welding certificates.
- F. Paint Compatibility Certificates: From manufacturers of topcoats applied over shop primers, certifying that shop primers are compatible with topcoats.
- G. Mill test reports for structural steel, including chemical and physical properties.
- H. Product Test Reports and Certifications: For the following:
 - 1. Bolts, nuts, and washers including mechanical properties and chemical analysis.
 - 2. Direct-tension indicators.
 - 3. Tension-control, high-strength bolt-nut-washer assemblies.
 - 4. Anchor Rods.
 - 5. Welding Consumables for Field Welds
 - 6. Shear stud connectors.

- 7. Shop primers.
- 8. Nonshrink grout.
- I. Source quality-control reports including nondestructive testing (NDT) reports and AISC 360, Section N3.2 items 1 to 3, and 5 to 11.
- J. Fabricator Certificates: Fabricator's Certificate of Compliance per Division 1 Section "Special Inspections" at completion of fabrication signed by fabricator certifying that structural steel was fabricated in accordance with construction documents.

1.6 QUALITY ASSURANCE

- A. Fabricator Qualifications: A qualified fabricator that participates in the AISC Quality Certification Program and is designated an AISC-Certified Plant, Category BU (Certified Building Fabricator).
- B. Installer Qualifications: A company specializing in performing the work of this Section with a minimum of 10 years documented experience.
- C. Steel Detailer Qualifications: Connections not detailed on the Drawings shall be designed by the fabricator under the direct supervision of a Professional Structural Engineer experienced in design of this work and licensed in the Project state.
- D. Welding Qualifications: Qualify procedures and personnel according to AWS D1.1/D1.1M, "Structural Welding Code - Steel."
 - 1. Welders and welding operators performing work on bottom-flange, demand-critical welds shall pass the supplemental welder qualification testing, as required by AWS D1.8. FCAW-S and FCAW-G shall be considered separate processes for welding personnel qualification.
- E. Comply with applicable provisions of the following specifications and documents:
 - 1. AISC 303.
 - 2. AISC 341 and AISC 341s1.
 - 3. AISC 360.
 - 4. RCSC's "Specification for Structural Joints Using High-Strength Bolts."

1.7 DELIVERY, STORAGE, AND HANDLING

- A. Store materials to permit easy access for inspection and identification. Keep steel members off ground and spaced by using pallets, dunnage, or other supports and spacers. Protect steel members and packaged materials from corrosion and deterioration.
 - 1. Do not store materials on structure in a manner that might cause distortion, damage, or overload to members or supporting structures. Repair or replace damaged materials or structures as directed.
- B. Store fasteners in a protected place in sealed containers with manufacturer's labels intact.
 - 1. Fasteners may be repackaged provided the testing and inspecting agency observes repackaging and seals containers.
 - 2. Clean and relubricate bolts and nuts that become dry or rusty before use.
 - 3. Comply with manufacturers' written recommendations for cleaning and lubricating ASTM F 1852 fasteners and for retesting fasteners after lubrication.

1.8 COORDINATION

- A. Coordinate selection of shop primers with topcoats to be applied over them. Comply with paint and coating manufacturers' recommendations to ensure that shop primers and topcoats are compatible with one another.

- B. Coordinate installation of anchorage items to be embedded in or attached to other construction without delaying the Work. Provide setting diagrams, sheet metal templates, instructions, and directions for installation.

PART 2 - PRODUCTS

2.1 STRUCTURAL-STEEL MATERIALS

- A. W-Shapes: ASTM A 992/A 992M.
- B. Channels, Angles, M, S-Shapes: ASTM A 36/A 36M.
- C. Plate and Bar: ASTM A 36/A 36M. Use ASTM A 572/A 572M, Grade 50.
- D. Cold-Formed Hollow Structural Sections: ASTM A 500, Grade B, structural tubing.
- E. Steel Pipe: ASTM A 53/A 53M, Type E or S, Grade B.
 - 1. Weight Class: As indicated on the Drawings.
 - 2. Finish: Black except where indicated to be galvanized.
- F. Welding Electrodes: Comply with AWS requirements.
 - 1. Where welds are designated as Demand Critical, they shall be made with a filler metal capable of providing a minimum Charpy V-Notch toughness of 20 ft-lb at -20 degrees Fahrenheit as determined by the appropriate AWS classification test or manufacturer certification, and 40 ft-lb at 70 degrees Fahrenheit as determined by AISC 341 Appendix X or other approved method.
 - 2. All other welds used in members and connections in the SLRS shall be made with a filler metal that can produce welds that have a minimum Charpy V-Notch toughness of 20 ft-lb at 0 degrees Fahrenheit as determined by the appropriate AWS A5 classification test method or manufacturer certification.

2.2 BOLTS, CONNECTORS, AND ANCHORS

- A. High-Strength Bolts, Nuts, and Washers: ASTM A 325, Type 1, heavy-hex steel structural bolts; ASTM A 563, Grade C, heavy-hex carbon-steel nuts; and ASTM F 436, Type 1, hardened carbon-steel washers; all with plain finish.
 - 1. Direct-Tension Indicators: ASTM F 959, Type 325, compressible-washer type with plain finish.
- B. High-Strength Bolts, Nuts, and Washers: ASTM A 490, Type 1, heavy-hex steel structural bolts or tension-control, bolt-nut-washer assemblies with splined ends; ASTM A 563, Grade DH, heavy-hex carbon-steel nuts; and ASTM F 436, Type 1, hardened carbon-steel washers with plain finish.
 - 1. Direct-Tension Indicators: ASTM F 959, Type 490, compressible-washer type with plain finish.
- C. Zinc-Coated High-Strength Bolts, Nuts, and Washers: ASTM A 325, Type 1, heavy-hex steel structural bolts; ASTM A 563, Grade DH heavy-hex carbon-steel nuts; and ASTM F 436, Type 1, hardened carbon-steel washers.
 - 1. Finish: Hot-dip zinc coating.
 - 2. Direct-Tension Indicators: ASTM F 959, Type 325, compressible-washer type with mechanically deposited zinc coating finish.
- D. Tension-Control, High-Strength Bolt-Nut-Washer Assemblies: ASTM F 1852, Type 1, heavy-hex head assemblies consisting of steel structural bolts with splined ends, heavy-hex carbon-steel nuts, and hardened carbon-steel washers.
 - 1. Finish: Plain, unless noted otherwise.

- E. Unheaded Anchor Rods: ASTM F 1554, Grade 36, ASTM F 1554, Grade 55, weldable, or ASTM F 1554, Grade 105, as indicated on the Drawings.
 - 1. Configuration: Straight.
 - 2. Nuts: ASTM A 563 heavy-hex carbon steel.
 - 3. Plate Washers: ASTM A 36/A 36M carbon steel.
 - 4. Washers: ASTM F 436, Type 1, hardened carbon steel.
 - 5. Finish: Plain, unless noted otherwise.
- F. Threaded Rods: ASTM A 36/A 36M.
 - 1. Nuts: ASTM A 563 heavy-hex carbon steel.
 - 2. Washers: ASTM F 436, Type 1, hardened carbon steel.
 - 3. Finish: Plain, unless noted otherwise.
- G. Clevises and Turnbuckles: Made from cold-finished carbon steel bars, ASTM A 108, Grade 1035.
- H. Eye Bolts and Nuts: Made from cold-finished carbon steel bars, ASTM A 108, Grade 1030.
- I. Sleeve Nuts: Made from cold-finished carbon steel bars, ASTM A 108, Grade 1018.

2.3 PRIMER

- A. Primer for High Performance Coatings or other finish coats: Comply with Division 09 painting Sections.
- B. Primer for all other uses: Fabricator's standard lead- and chromate-free, nonasphaltic, rust-inhibiting primer complying with MPI#79 and compatible with topcoat.
- C. Galvanizing Repair Paint: MPI#18, MPI#19, or SSPC-Paint 20.

2.4 GROUT

- A. Nonmetallic, Shrinkage-Resistant Grout: ASTM C 1107, factory-packaged, nonmetallic aggregate grout, noncorrosive and nonstaining, mixed with water to consistency suitable for application and a 30-minute working time.

2.5 FABRICATION

- A. Structural Steel: Fabricate and assemble in shop to greatest extent possible. Fabricate according to AISC's "Code of Standard Practice for Steel Buildings and Bridges" and AISC 360.
 - 1. Camber structural-steel members where indicated.
 - 2. Fabricate beams with rolling camber up.
 - 3. Identify high-strength structural steel according to ASTM A 6/A 6M and maintain markings until structural steel has been erected.
 - 4. Mark and match-mark materials for field assembly.
 - 5. Complete structural-steel assemblies, including welding of units, before starting shop-priming operations.
- B. Architecturally Exposed Structural Steel: Comply with fabrication requirements, including tolerance limits, of AISC's "Code of Standard Practice for Steel Buildings and Bridges" for structural steel identified as architecturally exposed structural steel.
 - 1. Fabricate with exposed surfaces smooth, square, and free of surface blemishes including pitting, rust, scale, seam marks, roller marks, rolled trade names, and roughness.
 - 2. Remove blemishes by filling or grinding or by welding and grinding, before cleaning, treating, and shop priming.
 - 3. Remove backing bars or runoff tabs, back gouge, and grind steel smooth.
- C. Thermal Cutting: Perform thermal cutting by machine to greatest extent possible.

1. Plane thermally cut edges to be welded to comply with requirements in AWS D1.1/D1.1M.
- D. Bolt Holes: Cut, drill, or punch standard bolt holes perpendicular to metal surfaces.
- E. Finishing: Accurately finish ends of columns and other members transmitting bearing loads.
- F. Cleaning: Clean and prepare steel surfaces that are to remain unpainted according to SSPC-SP 2, "Hand Tool Cleaning."
- G. Shear Connectors: Prepare steel surfaces as recommended by manufacturer of shear connectors. Use automatic end welding of headed-stud shear connectors according to AWS D1.1/D1.1M and manufacturer's written instructions.
- H. Holes: Provide holes required for securing other work to structural steel and for other work to pass through steel framing members.
 1. Cut, drill, or punch holes perpendicular to steel surfaces. Do not thermally cut bolt holes or enlarge holes by burning.
 2. Base plate Holes: Cut, drill, mechanically thermal cut, or punch holes perpendicular to steel surfaces.
 3. Weld threaded nuts to framing and other specialty items indicated to receive other work.

2.6 SHOP CONNECTIONS

- A. High-Strength Bolts: Shop install high-strength bolts according to RCSC's "Specification for Structural Joints Using High-Strength Bolts" for type of bolt and type of joint specified.
 1. Joint Type: As indicated on the Drawings.
- B. Weld Connections: Comply with AWS D1.1/D1.1M[and **AWS D1.8/D1.8M**] for tolerances, appearances, welding procedure specifications, weld quality, and methods used in correcting welding work.
 1. Assemble and weld built-up sections by methods that will maintain true alignment of axes without exceeding tolerances in AISC 303 for mill material.
 2. Architecturally Exposed Structural Steel: Verify that weld sizes, fabrication sequence, and equipment used will limit distortions to allowable tolerances. Prevent weld show-through on exposed steel surfaces.
 - a. Remove backing bars or runoff tabs, back gouge, and grind steel smooth.
 - b. Grind butt welds flush.
 - c. Grind or fill exposed fillet welds to smooth profile. Dress exposed welds.

2.7 SHOP PRIMING

- A. Shop prime steel surfaces except the following:
 1. Surfaces embedded in concrete or mortar. Extend priming of partially embedded members to a depth of 2 inches.
 2. Surfaces to be field welded.
 3. Surfaces to receive composite shear studs.
 4. Surfaces to be high-strength bolted with slip-critical connections.
 5. Surfaces to receive sprayed fire-resistive materials (applied fireproofing).
 6. Galvanized surfaces.
- B. Surface Preparation: Clean surfaces to be painted. Remove loose rust and mill scale and spatter, slag, or flux deposits. Prepare surfaces according to the following specifications and standards:
 1. SSPC-SP 3, "Power Tool Cleaning." For steel not receiving a finish coat and not subjected to extended weathering.

2. SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning." For steel receiving a finish coat or subject to extended weathering.
- C. Priming: Immediately after surface preparation, apply primer according to manufacturer's written instructions and at rate recommended by SSPC to provide a minimum dry film thickness of 2.5mils. Use priming methods that result in full coverage of joints, corners, edges, and exposed surfaces.
 1. Stripe paint corners, crevices, bolts, welds, and sharp edges.
 2. Apply two coats of shop paint to surfaces that are inaccessible after assembly or erection. Change color of second coat to distinguish it from first.

2.8 GALVANIZING

- A. Hot-Dip Galvanized Finish: Apply zinc coating by the hot-dip process to structural steel according to ASTM A 123/A 123M.
 1. Fill vent and drain holes that will be exposed in the finished Work unless they will function as weep holes, by plugging with zinc solder and filing off smooth.
 2. Galvanize lintels and shelf angles attached to structural-steel frame and located in exterior walls.
 3. Galvanize exposed structural steel where indicated on drawings.

2.9 SOURCE QUALITY CONTROL

- A. Fabricator Quality Control: Fabricator quality control shall be in accordance with AISC 360, Chapter N. Submit test reports and certifications listed in AISC 360, Section N3.2 for review by Special Inspector. Fabricator shall pay for and provide nondestructive testing (NDT) of all complete joint penetration shop welds by ultrasonic inspection per ASTM E 164. NDT shall be performed by NDT testing personnel qualified in accordance with AISC 360 Section N4.3. Submit NDT reports.
- B. Testing Agency: Owner may engage an independent testing and inspecting agency to perform shop tests and inspections and prepare test reports.
 1. Provide testing agency with access to places where structural-steel work is being fabricated or produced to perform tests and inspections.
- C. Correct deficiencies in Work that test reports and inspections indicate does not comply with the Contract Documents.
- D. Bolted Connections: Shop-bolted connections will be tested and inspected according to RCSC's "Specification for Structural Joints Using High-Strength Bolts."
- E. Welded Connections: In addition to visual inspection of all shop welds, all full penetration welds shall be ultrasonic tested and inspected according to AWS D1.1/D1.1M and ASTM E 164.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Contractor shall check all architecturally exposed structural steel members upon delivery for twist, kinks, gouges or other imperfections which may result in rejection of the appearance of the member. Coordinate remedial action with fabricator prior to erecting steel.

3.2 PREPARATION

- A. Provide temporary shores, guys, braces, and other supports during erection to keep structural steel secure, plumb, and in alignment against temporary construction loads and loads equal in intensity to design loads. Remove temporary supports when permanent structural steel, connections, and bracing are in place unless otherwise indicated.

1. Do not remove temporary shoring supporting composite deck construction until cast-in-place concrete has attained its design compressive strength.

3.3 ERECTION

- A. Set structural steel accurately in locations and to elevations indicated and according to AISC 303 and AISC 360.
- B. Base Plates: Clean concrete- and masonry-bearing surfaces of bond-reducing materials, and roughen surfaces prior to setting plates. Clean bottom surface of plates.
 1. Set plates for structural members on wedges, shims, or setting nuts as required.
 2. Weld plate washers to top of base plate.
 3. Snug-tighten anchor rods after supported members have been positioned and plumbed. Do not remove wedges or shims but, if protruding, cut off flush with edge of plate before packing with grout.
 4. Promptly pack grout solidly between bearing surfaces and plates so no voids remain. Neatly finish exposed surfaces; protect grout and allow to cure. Comply with manufacturer's written installation instructions for shrinkage-resistant grouts.
- C. Maintain erection tolerances of structural steel and architecturally exposed structural steel within AISC's "Code of Standard Practice for Steel Buildings and Bridges." Edge angles and bent plates, masonry ledgers and other miscellaneous fascia support steel shall be erected to meet the tolerance requirements for Adjustable Items.
- D. Align and adjust various members that form part of complete frame or structure before permanently fastening. Before assembly, clean bearing surfaces and other surfaces that will be in permanent contact with members. Perform necessary adjustments to compensate for discrepancies in elevations and alignment.
 1. Level and plumb individual members of structure.
- E. Splice members only where indicated.
- F. Remove erection bolts on welded, architecturally exposed structural steel; fill holes with plug welds; and grind smooth at exposed surfaces.
- G. Do not use thermal cutting during erection unless approved by Architect. Finish thermally cut sections within smoothness limits in AWS D1.1/D1.1M.
- H. Do not enlarge unfair holes in members by burning or using drift pins. Ream holes that must be enlarged to admit bolts.
- I. Shear Connectors: Prepare steel surfaces as recommended by manufacturer of shear connectors. Use automatic end welding of headed-stud shear connectors according to AWS D1.1/D1.1M and manufacturer's written instructions.

3.4 FIELD CONNECTIONS

- A. High-Strength Bolts: Install high-strength bolts according to RCSC's "Specification for Structural Joints Using High-Strength Bolts" for type of bolt and type of joint specified.
 1. Joint Type: As indicated on the Drawings.
- B. Weld Connections: Comply with AWS D1.1/D1.1M for tolerances, appearances, welding procedure specifications, weld quality, and methods used in correcting welding work.
 1. Comply with AISC 303 and AISC 360 for bearing, alignment, adequacy of temporary connections, and removal of paint on surfaces adjacent to field welds.
 2. Assemble and weld built-up sections by methods that will maintain true alignment of axes without exceeding tolerances in AISC's "Code of Standard Practice for Steel Buildings and Bridges" for mill material.

3. Architecturally Exposed Structural Steel: Verify that weld sizes, fabrication sequence, and equipment used will limit distortions to allowable tolerances. Prevent weld show-through on exposed steel surfaces.
 - a. Remove backing bars or runoff tabs, back gouge, and grind steel smooth.
 - b. Grind butt welds flush.
 - c. Grind or fill exposed fillet welds to smooth profile. Dress exposed welds.

3.5 FIELD QUALITY CONTROL

- A. Testing Agency: Owner will engage a qualified independent testing and inspecting agency to inspect field welds and high-strength bolted connections in accordance with Division 01 Section "Structural Testing and Special Inspection Services" and AISC 360, Chapter N.
- B. Bolted Connections: Bolted connections will be tested and inspected according to RCSC's "Specification for Structural Joints Using High-Strength Bolts."
- C. Welded Connections: Field welds will be visually inspected according to AWS D1.1/D1.1M.
 1. In addition to visual inspection of all field welds, all full penetration welds will be ultrasonic tested and inspected according to AWS D1.1/D1.1M and ASTM E 164.
- D. In addition to visual inspection, test and inspect field-welded shear connectors according to requirements in AWS D1.1/D1.1M for stud welding and as follows:
 1. Perform bend tests if visual inspections reveal either a less-than-continuous 360-degree flash or welding repairs to any shear connector.
 2. Conduct tests on additional shear connectors if weld fracture occurs on shear connectors already tested, according to requirements in AWS D1.1/D1.1M.
- E. Architecturally Exposed Structural Steel acceptance: The Architect shall observe the AESS steel in place and determine acceptability in keeping with the requirements of this section.
- F. Correct deficiencies in Work that test reports and inspections indicate does not comply with the Contract Documents.

3.6 REPAIRS AND PROTECTION

- A. Galvanized Surfaces: Clean areas where galvanizing is damaged or missing and repair galvanizing to comply with ASTM A 780.
- B. Touchup Painting: Immediately after erection, clean exposed areas where primer is damaged or missing and paint with the same material as used for shop painting to comply with SSPC-PA 1 for touching up shop-painted surfaces.
 1. Clean and prepare surfaces by SSPC-SP 2 hand-tool cleaning or SSPC-SP 3 power-tool cleaning.
- C. Touchup Painting: Cleaning and touchup painting are specified in Division 09 painting Sections.

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SECTION 052100
STEEL JOIST FRAMING

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. This Section includes the following:
 - 1. K-series steel joists.
 - 2. Long-span steel joists.
 - 3. Joist accessories.
- B. Related Sections include the following:
 - 1. Division 01 Section "Structural Testing and Special Inspection Services" for Fabricator's Certificate of Compliance and quality control.
 - 2. Division 03 Section "Cast-in-Place Concrete" for installing bearing plates in concrete.
 - 3. Division 05 Section "Structural Steel Framing" for bearing plates and anchor rods.

1.3 DEFINITIONS

- A. SJI "Specifications": Steel Joist Institute's "Standard Specifications, Load Tables and Weight Tables for Steel Joists and Joist Girders."
- B. Special Joists: Steel joists or joist girders requiring modification by manufacturer to support nonuniform, unequal, or special loading conditions that invalidate load tables in SJI's "Specifications."

1.4 PERFORMANCE REQUIREMENTS

- A. Structural Performance: Provide special joists and connections capable of withstanding design loads indicated.
- B. Design special joists to withstand design loads with live load deflections no greater than the following, unless noted otherwise on Drawings:
 - 1. Floor Joists: Vertical deflection of 1/360 of the span.
 - 2. Roof Joists: Vertical deflection of 1/240 of the span.
- C. Design all joists to withstand a two hundred pound vertical concentrated live bend load at any location along the top or bottom chord, acting concurrently with all other design loads.

1.5 SUBMITTALS

- A. Product Data: For each type of joist, accessory, and product indicated.
- B. Shop Drawings: Show layout, designation, number, type, location, and spacings of joists. Include joining and anchorage details, bracing, bridging, joist accessories; splice and connection locations and details; and attachments to other construction.
 - 1. Indicate locations and details of bearing plates to be embedded in other construction.
 - 2. Show loading diagrams for all special joists, indicating the magnitude and location of all distributed and concentrated loads.

3. Provide comprehensive engineering analysis of special joists signed and sealed by the qualified professional engineer responsible for its preparation and licensed in the project state.
- C. Welding certificates.
- D. Manufacturer Certificates: Fabricator's Certificate of Compliance per Division 1 Section "Special Inspections" at completion of fabrication signed by manufacturer certifying that joists were fabricated in accordance with construction documents.
- E. Mill Certificates: Signed by bolt manufacturers certifying that bolts comply with requirements.
- F. Qualification Data: For manufacturer and professional engineer.

1.6 QUALITY ASSURANCE

- A. Manufacturer Qualifications: A manufacturer certified by SJI to manufacture joists complying with applicable standard specifications and load tables of SJI "Specifications."
 1. Manufacturer's responsibilities include providing professional engineering services for designing special joists to comply with performance requirements.
- B. SJI Specifications: Comply with standard specifications in SJI's "Specifications" that are applicable to types of joists indicated.
- C. Welding: Qualify procedures and personnel according to AWS D1.1/D1.1M, "Structural Welding Code - Steel."

1.7 DELIVERY, STORAGE, AND HANDLING

- A. Deliver, store, and handle joists as recommended in SJI's "Specifications."
- B. Protect joists from corrosion, deformation, and other damage during delivery, storage, and handling.

1.8 SEQUENCING

- A. Deliver steel bearing plates to be built into cast-in-place concrete and masonry construction.

PART 2 - PRODUCTS

2.1 MATERIALS

- A. Steel: Comply with SJI's "Specifications" for web and steel-angle chord members.
- B. Carbon-Steel Bolts and Threaded Fasteners: ASTM A 307, Grade A, carbon-steel, hex-head bolts and threaded fasteners; carbon-steel nuts; and flat, unhardened steel washers.
 1. Finish: Plain, uncoated
- C. Welding Electrodes: Comply with AWS standards.

2.2 PRIMERS

- A. Primer: SSPC-Paint 15, or manufacturer's standard shop primer complying with performance requirements in SSPC-Paint 15.

2.3 K-SERIES STEEL JOISTS

- A. Manufacture steel joists of type indicated according to "Standard Specifications for Open Web Steel Joists, K-Series" in SJI's "Specifications," with steel-angle top- and bottom-chord members, underslung ends, and parallel top chord.
 - 1. Joist Type: K-series steel joists.
- B. Steel Joist Substitutes: Manufacture according to "Standard Specifications for Open Web Steel Joists, K-Series" in SJI's "Specifications," with steel-angle or -channel members.
- C. Comply with AWS requirements and procedures for shop welding, appearance, quality of welds, and methods used in correcting welding work.
- D. No penetrations, other than by approved deck fasteners, shall be made in joist members without the written approval of the joist manufacturer's professional engineer.
- E. Top-Chord Extensions: Extend top chords of joists with SJI's Type S top-chord extensions where indicated, complying with SJI's "Specifications."
- F. Extended Ends: Extend bearing ends of joists with SJI's Type R extended ends where indicated, complying with SJI's "Specifications."
- G. Camber joists according to SJI's "Specifications" or as otherwise noted.
- H. Equip bearing ends of joists with manufacturer's standard beveled ends or sloped shoes if joist slope exceeds 1/4 inch per 12 inches.

2.4 LONG-SPAN STEEL JOISTS

- A. Manufacture steel joists according to "Standard Specifications for Longspan Steel Joists, LH-Series and Deep Longspan Steel Joists, DLH-Series" in SJI's "Specifications," with steel-angle top- and bottom-chord members; of joist type and end and top-chord arrangements as indicated.
 - 1. Joist Type: LH-series steel joists and DLH-series steel joists.
 - 2. End Arrangement: Underslung.
 - 3. Top-Chord Arrangement: Parallel unless otherwise indicated
- B. Comply with AWS requirements and procedures for shop welding, appearance, quality of welds, and methods used in correcting welding work.
- C. No penetrations, other than by approved deck fasteners, shall be made in joist members without the written approval of the joist manufacturer's professional engineer.
- D. Camber long-span steel joists according to SJI's "Specifications" or as otherwise indicated.
- E. Equip bearing ends of joists with manufacturer's standard beveled ends or sloped shoes if joist slope exceeds 1/4 inch per 12 inches.

2.5 JOIST ACCESSORIES

- A. Bridging: Fabricate as indicated and according to SJI's "Specifications." Furnish additional erection bridging if required for stability.
- B. Steel bearing plates with integral anchorages are specified in Division 05 Section "Metal Fabrications."

- C. Supply ceiling extensions, either extended bottom-chord elements or a separate extension unit of enough strength to support ceiling construction. Extend ends to within 1/2 inch of finished wall surface, unless otherwise indicated.
- D. Supply miscellaneous accessories, including splice plates and bolts required by joist manufacturer to complete joist installation.

2.6 CLEANING AND SHOP PAINTING

- A. Clean and remove loose scale, heavy rust, and other foreign materials from fabricated joists and accessories by hand-tool cleaning, SSPC-SP 2 or power-tool cleaning, SSPC-SP 3.
- B. Do not prime paint joists and accessories to receive sprayed fire-resistive materials.
- C. Apply 1 coat of shop primer to joists and joist accessories to be primed to provide a continuous, dry paint film not less than 1 mil thick.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine supporting substrates, embedded bearing plates, and abutting structural framing for compliance with requirements for installation tolerances and other conditions affecting performance.
 - 1. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 INSTALLATION

- A. Do not install joists until supporting construction is in place and secured.
- B. Install joists and accessories plumb, square, and true to line; securely fasten to supporting construction according to SJI's "Specifications," joist manufacturer's written recommendations, and requirements in this Section.
 - 1. Before installation, splice joists delivered to Project site in more than one piece.
 - 2. Space, adjust, and align joists accurately in location before permanently fastening.
 - 3. Install temporary bracing and erection bridging, connections, and anchors to ensure that joists are stabilized during construction.
 - 4. Delay rigidly connecting bottom-chord extensions to columns or supports until dead loads have been applied.
- C. Field weld joists to supporting steel bearing plates and framework where indicated. Coordinate welding sequence and procedure with placement of joists. Comply with AWS requirements and procedures for welding, appearance and quality of welds, and methods used in correcting welding work.
- D. Bolt joists to supporting steel framework using carbon-steel bolts.
- E. Install and connect bridging concurrently with joist erection, before construction loads are applied. Anchor ends of bridging lines at top and bottom chords if terminating at walls or beams.

3.3 FIELD QUALITY CONTROL

- A. Testing Agency: Owner will engage a qualified independent testing and inspecting agency to inspect field welds and bolted connections and to perform field tests and inspections and prepare test and inspection reports in accordance with Division 01 Section "Structural Testing and Special Inspection Services".

- B. Field welds will be visually inspected according to AWS D1.1/D1.1M.
- C. Bolted connections will be visually inspected.
- D. High-strength, field-bolted connections will be tested and verified according to procedures in RCSC's "Specification for Structural Joints Using High-Strength Bolts."
- E. Correct deficiencies in Work that test and inspection reports have indicated are not in compliance with specified requirements.
- F. Additional testing will be performed to determine compliance of corrected Work with specified requirements.

3.4 REPAIRS AND PROTECTION

- A. Touchup Painting: After installation, promptly clean, prepare, and prime or reprime field connections, rust spots, and abraded surfaces of prime-painted joists, bearing plates, abutting structural steel, and accessories.
 - 1. Clean and prepare surfaces by hand-tool cleaning, SSPC-SP 2, or power-tool cleaning, SSPC-SP 3.
 - 2. Apply a compatible primer of same type as shop primer used on adjacent surfaces.
- B. Provide final protection and maintain conditions, in a manner acceptable to manufacturer and Installer, which ensures that joists and accessories are without damage or deterioration at time of Material Completion.

END OF SECTION 052100

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SECTION 053100

STEEL DECKING

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. This Section includes the following:
 - 1. Roof deck.
 - 2. Composite floor deck.
- B. Related Sections include the following:
 - 1. Division 01 Section "Structural Testing and Special Inspection Services" for field quality control.
 - 2. Division 03 Section "Cast-in-Place Concrete" for concrete fill.
 - 3. Division 05 Section "Structural Steel Framing" for steel angle framing and shop- and field-welded shear connectors.
 - 4. Division 09 painting Sections for repair painting of primed deck.

1.3 SUBMITTALS

- A. Product Data: For each type of deck, accessory, and product indicated.
- B. Shop Drawings: Show layout and types of deck panels, anchorage details, reinforcing channels, pans, cut deck openings, special jointing, accessories, and attachments to other construction.
- C. Product Certificates: For each type of steel deck, signed by product manufacturer.
- D. Welding certificates.
- E. Mechanical Fasteners: Proposed alternate fastener size, spacing and load capacity data.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency, indicating that each of the following complies with requirements:
 - 1. Powder-actuated mechanical fasteners.
 - 2. Acoustical roof deck.

1.4 QUALITY ASSURANCE

- A. Manufacturer Qualifications: A Member of the Steel Deck Institute.
- B. Installer Qualifications: An experienced installer who has completed steel deck similar in material, design, and extent to that indicated for this Project and whose work has resulted in construction with a record of successful in-service performance.
- C. Welding: Qualify procedures and personnel according to AWS D1.3, "Structural Welding Code - Sheet Steel."
- D. Fire-Test-Response Characteristics: Where indicated, provide steel deck units identical to those tested for fire resistance per ASTM E 119 by a testing and inspecting agency acceptable to the Architect.

1. Fire-Resistance Ratings: Indicated by design designations of applicable testing and inspecting agency.
 2. Steel deck units shall be identified with appropriate markings of applicable testing and inspecting agency.
- E. AISI Specifications: Comply with calculated structural characteristics of steel deck according to AISI's "North American Specification for the Design of Cold-Formed Steel Structural Members."
- F. FMG Listing: Provide steel roof deck evaluated by FMG and listed in its "Approval Guide, Building Materials" for Class 1 fire rating and Class 1-90 windstorm ratings.

1.5 DELIVERY, STORAGE, AND HANDLING

- A. Protect steel deck from corrosion, deformation, and other damage during delivery, storage, and handling.
- B. Stack steel deck on platforms or pallets and slope to provide drainage. Protect with a waterproof covering and ventilate to avoid condensation.
1. Protect and ventilate acoustical cellular roof deck with factory-installed insulation to maintain insulation free of moisture.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Available Manufacturers: Manufacturers offering products that may be incorporated into the Work include the following:
1. Steel Deck:
 - a. ASC Steel Deck
 - b. Canam Steel Corp.;The Canam Manac Group.
 - c. Consolidated Systems, Inc.
 - d. Epic Metals Corporation.
 - e. Marlyn Steel Decks, Inc.
 - f. New Millennium Building Systems, LLC.
 - g. Nucor Corp.; Vulcraft Division.
 - h. Valley Joist; Division of EBSCO Industries, Inc.
 - i. Verco Decking, Inc.

2.2 ROOF DECK

- A. Steel Roof Deck: Fabricate panels, without top-flange stiffening grooves, to comply with ANSI/SDI-RD1.0 Standard for Steel Roof Deck, and with the following:
1. Prime-Painted Steel Sheet: ASTM A 1008/A 1008M, Structural Steel (SS), Grade 33 minimum, shop primed with manufacturer's standard baked-on, rust-inhibitive primer.
 - a. Color: Manufacturer's standard.
 2. Galvanized Steel Sheet: ASTM A 653/A 653M, Structural Steel (SS), Grade 33, G90 zinc coating.
 3. Deck Profile: As indicated on the Drawings.
 4. Profile Depth: As indicated on the Drawings.
 5. Design Uncoated-Steel Thickness: As indicated on the Drawings.
 6. Span Condition: As indicated on the Drawings.
 7. Side Laps: Overlapped.

2.3 COMPOSITE FLOOR DECK

- A. Composite Steel Floor Deck: Fabricate panels, with integrally embossed or raised pattern ribs and interlocking side laps, to comply with ANSI/SDI-C1.0 Standard for Composite Floor Deck, with the minimum section properties indicated, and with the following:

1. Galvanized Steel Sheet: ASTM A 653/A 653M, Structural Steel (SS), Grade 50, G60 zinc coating.
2. Profile Depth: As indicated on the Drawings.
3. Design Uncoated-Steel Thickness: As indicated on the Drawings.
4. Span Condition: As indicated on the Drawings.

2.4 ACCESSORIES

- A. General: Provide manufacturer's standard accessory materials for deck that comply with requirements indicated.
- B. Mechanical Fasteners: Corrosion-resistant, low-velocity, power-actuated or pneumatically driven carbon-steel fasteners; or self-drilling, self-threading screws.
- C. Side-Lap Fasteners: Corrosion-resistant, hexagonal washer head; self-drilling, carbon-steel screws, No. 10 minimum diameter.
- D. Flexible Closure Strips: Vulcanized, closed-cell, synthetic rubber.
- E. Miscellaneous Sheet Metal Deck Accessories: Steel sheet, minimum yield strength of 33,000 psi, not less than 0.0359-inch design uncoated thickness, of same material and finish as deck; of profile indicated or required for application.
- F. Pour Stops and Girder Fillers: Steel sheet, minimum yield strength of 33,000 psi, of same material and finish as deck, and of thickness and profile recommended by SDI Publication No. 31 for overhang and slab depth.
- G. Column Closures, End Closures, and Z-Closures: Steel sheet, of same material, finish, and thickness as deck, unless otherwise indicated.
- H. Hips, Valleys, Ridge and Cover Plates: Steel sheet, of same material, finish, and thickness as deck, 6" minimum in width, unless otherwise indicated.
- I. Recessed Sump Pans: Single-piece steel sheet, 0.0747 inch thick, of same material and finish as deck, with 3-inch- wide flanges and level recessed pans of 1-1/2-inch minimum depth. For drains, cut holes in the field.
- J. Flat Sump Plate: Single-piece steel sheet, 0.0747 inch thick, of same material and finish as deck. For drains, cut holes in the field.
- K. Galvanizing Repair Paint: ASTM A 780.
- L. Repair Paint: Manufacturer's standard rust-inhibitive primer of same color as primer.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine supporting frame and field conditions for compliance with requirements for installation tolerances and other conditions affecting performance.

3.2 INSTALLATION, GENERAL

- A. Install deck panels and accessories according to applicable Standards and commentary in SDI Publication No. 31, Steel Deck Institute Design Manual, manufacturer's written instructions, and requirements in this Section.
- B. Install temporary shoring before placing deck panels, if required to meet deflection limitations.
- C. Locate deck bundles to prevent overloading of supporting members.

- D. Place deck panels on supporting frame and adjust to final position with ends accurately aligned and bearing on supporting frame before being permanently fastened. Do not stretch or contract side-lap interlocks.
- E. Place deck panels flat and square and fasten to supporting frame without warp or deflection.
- F. Cut and neatly fit deck panels and accessories around openings and other work projecting through or adjacent to deck.
- G. Provide additional reinforcement and closure pieces at openings as required for strength, continuity of deck, and support of other work.
- H. Provide hip, valley and ridge plates at all changes in deck plane orientation unless otherwise noted. Fasten to supporting deck at 12 inches on center, each side, unless noted otherwise.
- I. Provide cover plates where deck span changes direction unless otherwise noted. Fasten to supporting deck at 12 inches on center, each side, unless noted otherwise.
- J. Comply with AWS requirements and procedures for manual shielded metal arc welding, appearance and quality of welds, and methods used for correcting welding work.
- K. Mechanical fasteners may be used in lieu of welding to fasten deck. Locate mechanical fasteners and install according to deck manufacturer's written instructions. Diaphragm shear and uplift load capacity of alternate mechanical fasteners shall meet or exceed the capacity of specified welded fasteners. Submit proposed fastener size, spacing and load capacity data.

3.3 ROOF-DECK INSTALLATION

- A. Fasten roof-deck panels to steel supporting members by arc spot (puddle) welds of the surface diameter indicated as follows:
 - 1. Weld Diameter: 5/8 inch, nominal.
 - 2. Weld Spacing: Weld edge and interior ribs of deck units with a minimum of two welds per deck unit at each support. Space welds as indicated on the Drawings.
- B. Side-Lap and Perimeter Edge Fastening: Fasten side laps and perimeter edges of panels between supports, at intervals indicated on the Drawings but not exceeding the lesser of 1/2 of the span or 24 inches, and as follows:
 - 1. Mechanically fasten with self-drilling, No. 10 diameter or larger, carbon-steel screws.
- C. End Bearing: Install deck ends over supporting frame with a minimum end bearing of 1-1/2 inches, with end joints as follows:
 - 1. End Joints: Lapped 2 inches minimum.
- D. Roof Sump Pans and Sump Plates: Install over openings provided in roof deck and mechanically fasten flanges to top of deck. Space mechanical fasteners not more than 12 inches apart with at least one fastener at each corner.
 - 1. Install reinforcing channels or zees in ribs to span between supports and mechanically fasten.
- E. Miscellaneous Roof-Deck Accessories: Install hip, ridge and valley plates, finish strips, end closures, cover plates and reinforcing channels according to deck manufacturer's written instructions unless noted otherwise. Weld or mechanically fasten to substrate to provide a complete deck installation.
- F. Roof Deck Openings: Steel deck openings shall be reinforced as follows:
 - 1. Steel deck openings 6" or less in size do not require reinforcing.
 - 2. Steel deck openings greater than 12" in size shall be reinforced with a structural steel frame as indicated on the Drawings.
 - 3. Steel deck openings greater than 6 inches but less than 12 inches in size shall be reinforced as follows, unless specifically detailed otherwise on the Drawings:

- a. Install 2x2x1/4 inch structural steel angle each side of opening, perpendicular to the deck flutes and extending a minimum of two flutes beyond each side of the opening.
 - b. Weld or mechanically fasten each deck flute to the angles.
- G. Flexible Closure Strips: Install flexible closure strips over partitions, walls, and where indicated. Install with adhesive according to manufacturer's written instructions to ensure complete closure.
- H. Hanging Loads: Do not hang loads from roof deck.

3.4 FLOOR-DECK INSTALLATION

- A. Fasten floor-deck panels to steel supporting members by arc spot (puddle) welds of the surface diameter indicated and as follows:
 - 1. Weld Diameter: 5/8 inch, nominal.
 - 2. Weld Spacing: Space and locate welds as indicated on the Drawings.
 - 3. Weld Washers: Install weld washers at each weld location if minimum uncoated steel thickness is less than 0.028 inch (22 ga) (0.71 mm).
- B. Side-Lap and Perimeter Edge Fastening: Fasten side laps and perimeter edges of panels between supports, as indicated on the Drawings and at intervals not exceeding the lesser of half of the span or 24 inches, and as follows:
 - 1. Mechanically fasten with self-drilling, No. 10 diameter or larger, carbon-steel screws.
 - 2. Fasten with a minimum of 1-1/2-inch- long welds.
- C. End Bearing: Install deck ends over supporting frame with a minimum end bearing of 1-1/2 inches with end joints as follows:
 - 1. End Joints: Butted.
- D. Pour Stops and Girder Fillers: Weld steel sheet pour stops and girder fillers to supporting structure according to SDI recommendations, unless otherwise indicated.
- E. Floor-Deck Closures: Weld steel sheet column closures, cell closures, and Z-closures to deck, according to SDI recommendations, to provide tight-fitting closures at open ends of ribs and sides of deck.
- F.

3.5 FIELD QUALITY CONTROL

- A. Testing Agency: Owner will engage a qualified independent testing and inspecting agency to perform field tests and inspections and prepare test reports. See Division 01 Section "Structural Testing and Special Inspection Services."
- B. Field welds will be subject to inspection.
- C. Testing agency will report inspection results promptly and in writing to Contractor and Architect.
- D. Remove and replace work that does not comply with specified requirements.
- E. Additional inspections, at Contractor's expense, will be performed to determine compliance of corrected work with specified requirements.

3.6 REPAIRS AND PROTECTION

- A. Galvanizing Repairs: Prepare and repair damaged galvanized coatings on both surfaces of deck with galvanized repair paint according to ASTM A 780 and manufacturer's written instructions. Touch-up all welds with galvanizing repair paint.
- B. Repair Painting: Wire brush and clean rust spots, welds, and abraded areas on both surfaces of prime-painted deck immediately after installation, and apply repair paint.
 - 1. Apply repair paint, of same color as adjacent shop-primed deck, to bottom surfaces of deck exposed to view.
- C. Provide final protection and maintain conditions to ensure that steel deck is without damage or deterioration at time of Material Completion.

END OF SECTION 05310

SECTION 054000
COLD-FORMED METAL FRAMING

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section Includes:
 - 1. Exterior non-load-bearing wall framing.
 - 2. Soffit framing.

1.3 ACTION SUBMITTALS

- A. Product Data: For each type of cold-formed steel framing product and accessory.
- B. Shop Drawings:
 - 1. Include layout, spacings, sizes, thicknesses, and types of cold-formed steel framing; fabrication; and fastening and anchorage details, including mechanical fasteners.
 - 2. Indicate reinforcing channels, opening framing, supplemental framing, strapping, bracing, bridging, splices, accessories, connection details, and attachment to adjoining work.
- C. Delegated-Design Submittal: For cold-formed steel framing.

1.4 INFORMATIONAL SUBMITTALS

- A. Qualification Data: For testing agency.
- B. Welding certificates.
- C. Product Test Reports: For each listed product, for tests performed by [manufacturer and witnessed by a qualified testing agency] [a qualified testing agency].
 - 1. Steel sheet.
 - 2. Expansion anchors.
 - 3. Power-actuated anchors.
 - 4. Mechanical fasteners.
 - 5. Vertical deflection clips.
 - 6. Horizontal drift deflection clips
 - 7. Miscellaneous structural clips and accessories.

1.5 QUALITY ASSURANCE

- A. Testing Agency Qualifications: Qualified according to ASTM E 329 for testing indicated.
- B. Product Tests: Mill certificates or data from a qualified independent testing agency[, or in-house testing with calibrated test equipment] indicating steel sheet complies with requirements, including base-metal thickness, yield strength, tensile strength, total elongation, chemical requirements, and metallic-coating thickness.
- C. Welding Qualifications: Qualify procedures and personnel according to the following:
 - 1. AWS D1.1/D1.1M, "Structural Welding Code - Steel."
 - 2. AWS D1.3/D1.3M, "Structural Welding Code - Sheet Steel."

- D. Comply with AISI S230 "Standard for Cold-Formed Steel Framing - Prescriptive Method for One and Two Family Dwellings."

1.6 DELIVERY, STORAGE, AND HANDLING

- A. Protect cold-formed steel framing from corrosion, moisture staining, deformation, and other damage during delivery, storage, and handling.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Manufacturers: Subject to compliance with requirements, [provide products by the following] [provide products by one of the following] [available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following]:
 - 1. AllSteel & Gypsum Products, Inc.
 - 2. Dietrich Metal Framing; a Worthington Industries Company.
 - 3. SCAFCO Corporation.
 - 4. Southeastern Stud & Components, Inc.

2.2 PERFORMANCE REQUIREMENTS

- A. Delegated Design: Engage a qualified professional engineer, as defined in Section 014000 "Quality Requirements," to design cold-formed steel framing.
- B. Structural Performance: Provide cold-formed steel framing capable of withstanding design loads within limits and under conditions indicated.
 - 1. Design Loads: [As indicated] <Insert design loads>.
 - 2. Deflection Limits: Design framing systems to withstand[design loads] without deflections greater than the following:
 - a. Exterior Load-Bearing Wall Framing: Horizontal deflection of [1/240] [1/360] [1/600] [1/720] of the wall height.
 - b. Interior Load-Bearing Wall Framing: Horizontal deflection of [1/240] [1/360] of the wall height under a horizontal load of 5 lbf/sq. ft..
 - c. Exterior Non-Load-Bearing Framing: Horizontal deflection of [1/240] [1/360] [1/600] [1/720] <Insert ratio> of the wall height.
 - d. Floor Joist Framing: Vertical deflection of [1/360] [1/480] for live loads and 1/240 for total loads of the span.
 - e. Roof Rafter Framing: Vertical deflection of [1/120] [1/240] [1/360] of the horizontally projected span for live loads.
 - f. Ceiling Joist Framing: Vertical deflection of [1/120] [1/240] [1/360] of the span for live loads and 1/240 for total loads of the span.
 - 3. Design framing systems to provide for movement of framing members located outside the insulated building envelope without damage or overstressing, sheathing failure, connection failure, undue strain on fasteners and anchors, or other detrimental effects when subject to a maximum ambient temperature change of 120 deg F.
 - 4. Design framing system to maintain clearances at openings, to allow for construction tolerances, and to accommodate live load deflection of primary building structure as follows:
 - a. Upward and downward movement of [1/2 inch] [3/4 inch] [1 inch] [1-1/2 inches].
 - 5. Design exterior non-load-bearing wall framing to accommodate horizontal deflection without regard for contribution of sheathing materials.
- C. Cold-Formed Steel Framing Design Standards:
 - 1. Wall Studs: AISI S211.
 - 2. Lateral Design: AISI S213.

- D. AISI Specifications and Standards: Unless more stringent requirements are indicated, comply with AISI S100 and AISI S200.
- E. Fire-Resistance Ratings: Comply with ASTM E 119; testing by a qualified testing agency. Identify products with appropriate markings of applicable testing agency.
 - 1. Indicate design designations from UL's "Fire Resistance Directory" or from the listings of another qualified testing agency.

2.3 COLD-FORMED STEEL FRAMING, GENERAL

- A. Steel Sheet: ASTM A 1003/A 1003M, Structural Grade, Type H, metallic coated, of grade and coating weight as follows:
 - 1. Grade: [ST33H] [ST50H] [As required by structural performance] <Insert grade>.
 - 2. Coating: [G60, A60, AZ50, or GF30] [G90 or equivalent] <Insert coating weight>.
- B. Steel Sheet for [Vertical Deflection] [Drift] Clips: ASTM A 653/A 653M, structural steel, zinc coated, of grade and coating as follows:
 - 1. Grade: [33] [50, Class 1] [As required by structural performance].
 - 2. Coating: [G60] [G90].

2.4 EXTERIOR NON-LOAD-BEARING WALL FRAMING

- A. Steel Studs: Manufacturer's standard C-shaped steel studs, of web depths indicated, punched, with stiffened flanges, and as follows:
 - 1. Minimum Base-Metal Thickness: 0.0538 inch.
 - 2. Flange Width: 1-5/8 inches.
 - 3. Section Properties: <Insert minimum allowable calculated section modulus, moment of inertia, and allowable moment>.
- B. Steel Track: Manufacturer's standard U-shaped steel track, of web depths indicated, unpunched, with unstiffened flanges, and as follows:
 - 1. Minimum Base-Metal Thickness: Matching steel studs.
 - 2. Flange Width: 1-1/4 inches.
- C. Vertical Deflection Clips: Manufacturer's standard [bypass] [head] clips, capable of accommodating upward and downward vertical displacement of primary structure through positive mechanical attachment to stud web.
 - 1. Manufacturers: Subject to compliance with requirements, [provide products by the following] [provide products by one of the following] [available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following]:
 - a. AllSteel & Gypsum Products, Inc.
 - b. ClarkWestern Building Systems, Inc.
 - c. Dietrich Metal Framing; a Worthington Industries company.
 - d. MarinoWARE.
 - e. SCAFCO Corporation.
 - f. Steel Network, Inc. (The).
 - g. Steeler, Inc.
- D. Drift Clips: Manufacturer's standard bypass or head clips, capable of isolating wall stud from upward and downward vertical displacement and lateral drift of primary structure through positive mechanical attachment to stud web and structure.

2.5 SOFFIT FRAMING

- A. Exterior Soffit Frame: Manufacturer's standard C-shaped steel sections, of web depths indicated, with stiffened flanges, and as follows:
 - 1. Minimum Base-Metal Thickness: 0.0538 inch 0.0966 inch.

2. Flange Width: 1-5/8 inches, minimum.
3. Section Properties: <Insert minimum allowable calculated section modulus, moment of inertia, and allowable moment>.

2.6 FRAMING ACCESSORIES

- A. Fabricate steel-framing accessories from steel sheet, ASTM A 1003/A 1003M, Structural Grade, Type H, metallic coated, of same grade and coating weight used for framing members.
- B. Provide accessories of manufacturer's standard thickness and configuration, unless otherwise indicated, as follows:
 1. Supplementary framing.
 2. Bracing, bridging, and solid blocking.
 3. Web stiffeners.
 4. Anchor clips.
 5. End clips.
 6. Gusset plates.
 7. Stud kickers and knee braces.
 8. Joist hangers and end closures.
 9. Hole reinforcing plates.
 10. Backer plates.

2.7 ANCHORS, CLIPS, AND FASTENERS

- A. Steel Shapes and Clips: ASTM A 36/A 36M, zinc coated by hot-dip process according to ASTM A 123/A 123M.
- B. Expansion Anchors: Fabricated from corrosion-resistant materials, with allowable load or strength design capacities calculated according to ICC-ES AC193 and ACI 318 greater than or equal to the design load, as determined by testing per ASTM E 488 conducted by a qualified testing agency.
- C. Power-Actuated Anchors: Fastener system of type suitable for application indicated, fabricated from corrosion-resistant materials, with allowable load capacities calculated according to ICC-ES AC70, greater than or equal to the design load, as determined by testing per ASTM E 1190 conducted by a qualified testing agency.
- D. Welding Electrodes: Comply with AWS standards.

2.8 MISCELLANEOUS MATERIALS

- A. Galvanizing Repair Paint: [SSPC-Paint 20 or MIL-P-21035B] [ASTM A 780].
- B. Nonmetallic, Nonshrink Grout: Premixed, nonmetallic, noncorrosive, nonstaining grout containing selected silica sands, portland cement, shrinkage-compensating agents, and plasticizing and water-reducing agents, complying with ASTM C 1107/C 1107M, with fluid consistency and 30-minute working time.
- C. Shims: Load bearing, high-density multimonomer plastic, and nonleaching; or of cold-formed steel of same grade and coating as framing members supported by shims.
- D. Sealer Gaskets: Closed-cell neoprene foam, 1/4 inch thick, selected from manufacturer's standard widths to match width of bottom track or rim track members.

2.9 FABRICATION

- A. Fabricate cold-formed steel framing and accessories plumb, square, and true to line, and with connections securely fastened, according to referenced AISI's specifications and standards, manufacturer's written instructions, and requirements in this Section.
 - 1. Fabricate framing assemblies using jigs or templates.
 - 2. Cut framing members by sawing or shearing; do not torch cut.
 - 3. Fasten cold-formed steel framing members by welding, screw fastening, clinch fastening, pneumatic pin fastening, or riveting as standard with fabricator. Wire tying of framing members is not permitted.
 - a. Comply with AWS D1.3/D1.3M requirements and procedures for welding, appearance and quality of welds, and methods used in correcting welding work.
 - b. Locate mechanical fasteners and install according to Shop Drawings, with screw penetrating joined members by no fewer than three exposed screw threads.
 - 4. Fasten other materials to cold-formed steel framing by welding, bolting, pneumatic pin fastening, or screw fastening, according to Shop Drawings.
- B. Reinforce, stiffen, and brace framing assemblies to withstand handling, delivery, and erection stresses. Lift fabricated assemblies to prevent damage or permanent distortion.
- C. Fabrication Tolerances: Fabricate assemblies level, plumb, and true to line to a maximum allowable tolerance variation of 1/8 inch in 10 feet and as follows:
 - 1. Spacing: Space individual framing members no more than plus or minus 1/8 inch from plan location. Cumulative error shall not exceed minimum fastening requirements of sheathing or other finishing materials.
 - 2. Squareness: Fabricate each cold-formed steel framing assembly to a maximum out-of-square tolerance of 1/8 inch.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine supporting substrates and abutting structural framing for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 PREPARATION

- A. Install load bearing shims or grout between the underside of load-bearing wall bottom track and the top of foundation wall or slab at locations with a gap larger than 1/4 inch to ensure a uniform bearing surface on supporting concrete or masonry construction.
- B. Install sealer gaskets at the underside of wall bottom track or rim track and at the top of foundation wall or slab at stud or joist locations.

3.3 INSTALLATION, GENERAL

- A. Cold-formed steel framing may be shop or field fabricated for installation, or it may be field assembled.
- B. Install cold-formed steel framing according to AISI S200 and to manufacturer's written instructions unless more stringent requirements are indicated.
- C. Install shop- or field-fabricated, cold-formed framing and securely anchor to supporting structure.

1. Screw, bolt, or weld wall panels at horizontal and vertical junctures to produce flush, even, true-to-line joints with maximum variation in plane and true position between fabricated panels not exceeding 1/16 inch.
- D. Install cold-formed steel framing and accessories plumb, square, and true to line, and with connections securely fastened.
 1. Cut framing members by sawing or shearing; do not torch cut.
 2. Fasten cold-formed steel framing members by welding, screw fastening, clinch fastening, or riveting. Wire tying of framing members is not permitted.
 - a. Comply with AWS D1.3/D1.3M requirements and procedures for welding, appearance and quality of welds, and methods used in correcting welding work.
 - b. Locate mechanical fasteners and install according to Shop Drawings, and complying with requirements for spacing, edge distances, and screw penetration.
- E. Install framing members in one-piece lengths unless splice connections are indicated for track or tension members.
- F. Install temporary bracing and supports to secure framing and support loads comparable in intensity to those for which structure was designed. Maintain braces and supports in place, undisturbed, until entire integrated supporting structure has been completed and permanent connections to framing are secured.
- G. Do not bridge building expansion joints with cold-formed steel framing. Independently frame both sides of joints.
- H. Install insulation, specified in Section 072100 "Thermal Insulation," in built-up exterior framing members, such as headers, sills, boxed joists, and multiple studs at openings, that are inaccessible on completion of framing work.
- I. Fasten hole reinforcing plate over web penetrations that exceed size of manufacturer's approved or standard punched openings.
- J. Erection Tolerances: Install cold-formed steel framing level, plumb, and true to line to a maximum allowable tolerance variation of 1/8 inch in 10 feet and as follows:
 1. Space individual framing members no more than plus or minus 1/8 inch from plan location. Cumulative error shall not exceed minimum fastening requirements of sheathing or other finishing materials.

3.4 EXTERIOR NON-LOAD-BEARING WALL INSTALLATION

- A. Install continuous tracks sized to match studs. Align tracks accurately and securely anchor to supporting structure as indicated.
- B. Fasten both flanges of studs to [top and] bottom track unless otherwise indicated. Space studs as follows:
 1. Stud Spacing: [12 inches] [16 inches] [19.2 inches] [24 inches] [As indicated].
 2. Stud Spacing: [300 mm] [400 mm] [480 mm] [600 mm] [As indicated].
- C. Set studs plumb, except as needed for diagonal bracing or required for nonplumb walls or warped surfaces and similar requirements.
- D. Isolate non-load-bearing steel framing from building structure to prevent transfer of vertical loads while providing lateral support.
 1. Connect vertical deflection clips to [bypassing] [infill] studs and anchor to building structure.
 2. Connect drift clips to cold-formed metal framing and anchor to building structure.

- E. Install horizontal bridging in wall studs, spaced vertically in rows indicated on Shop Drawings but not more than 48 inches apart. Fasten at each stud intersection.
 - 1. Top Bridging for Single Deflection Track: Install row of horizontal bridging within [12 inches] [18 inches] of single deflection track. Install a combination of bridging and stud or stud-track solid blocking of width and thickness matching studs, secured to stud webs or flanges.
 - a. Install solid blocking at [96-inch centers] [centers indicated] [centers indicated on Shop Drawings].
 - 2. Bridging: Cold-rolled steel channel, welded or mechanically fastened to webs of punched studs.
 - 3. Bridging: Combination of flat, taut, steel sheet straps of width and thickness indicated and stud-track solid blocking of width and thickness to match studs. Fasten flat straps to stud flanges and secure solid blocking to stud webs or flanges.
 - 4. Bridging: Proprietary bridging bars installed according to manufacturer's written instructions.
- F. Install miscellaneous framing and connections, including stud kickers, web stiffeners, clip angles, continuous angles, anchors, and fasteners, to provide a complete and stable wall-framing system.

3.5 FIELD QUALITY CONTROL

- A. Testing: Owner will engage a qualified independent testing and inspecting agency to perform field tests and inspections and prepare test reports.
- B. Field and shop welds will be subject to testing and inspecting.
- C. Testing agency will report test results promptly and in writing to Contractor and Architect.
- D. Remove and replace work where test results indicate that it does not comply with specified requirements.
- E. Additional testing and inspecting, at Contractor's expense, will be performed to determine compliance of replaced or additional work with specified requirements.

3.6 REPAIRS AND PROTECTION

- A. Galvanizing Repairs: Prepare and repair damaged galvanized coatings on fabricated and installed cold-formed steel framing with galvanized repair paint according to ASTM A 780 and manufacturer's written instructions.
- B. Provide final protection and maintain conditions, in a manner acceptable to manufacturer and Installer that ensures the cold-formed steel framing is without damage or deterioration at time of Substantial Completion.

END OF SECTION 054000

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ALPHARETTA CONFERENCE CENTER
AND HOTEL AT AVALON - 20130026

SECTION 054000 - 8

COLD-FORMED METAL FRAMING

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SECTION 055000
METAL FABRICATIONS

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section Includes:
 - 1. Steel framing and supports for ceiling-hung toilet compartments.
 - 2. Steel framing and supports for operable partitions.
 - 3. Steel framing and supports for overhead [doors] [and] [grilles].
 - 4. Steel framing and supports for countertops.
 - 5. Steel tube reinforcement for low partitions.
 - 6. Steel framing and supports for mechanical and electrical equipment.
 - 7. Steel framing and supports for applications where framing and supports are not specified in other Sections.
 - 8. Elevator machine beams[, hoist beams,] [and] [divider beams].
 - 9. Steel shapes for supporting elevator door sills.
 - 10. Shelf angles.
 - 11. Metal ladders.
 - 12. Ladder safety cages.
 - 13. Metal ships' ladders pipe crossovers.
 - 14. Metal floor plate[and supports].
 - 15. Structural-steel door frames.
 - 16. Miscellaneous steel trim including steel angle corner guards steel edgings loading-dock edge angles.
 - 17. Metal bollards.
 - 18. Pipe Downspout guards.
 - 19. Abrasive metal nosings treads thresholds.
 - 20. Cast-iron wheel guards.
 - 21. Metal downspout boots.
 - 22. Loose bearing and leveling plates for applications where they are not specified in other Sections.
- B. Products furnished, but not installed, under this Section include the following:
 - 1. Loose steel lintels.
 - 2. Anchor bolts, steel pipe sleeves, slotted-channel inserts, and wedge-type inserts indicated to be cast into concrete or built into unit masonry.
 - 3. Steel weld plates and angles for casting into concrete for applications where they are not specified in other Sections.

1.3 COORDINATION

- A. Coordinate selection of shop primers with topcoats to be applied over them. Comply with paint and coating manufacturers' written recommendations to ensure that shop primers and topcoats are compatible with one another.
- B. Coordinate installation of metal fabrications that are anchored to or that receive other work. Furnish setting drawings, templates, and directions for installing anchorages, including sleeves, concrete inserts, anchor bolts, and items with integral anchors, that are to be embedded in concrete or masonry. Deliver such items to Project site in time for installation.

1.4 ACTION SUBMITTALS

- A. Product Data: For the following:
 - 1. Nonslip aggregates and nonslip-aggregate surface finishes.
 - 2. Metal nosings and treads.
 - 3. Grout.
- B. Shop Drawings: Show fabrication and installation details.[Include plans, elevations, sections, and details of metal fabrications and their connections. Show anchorage and accessory items.] Provide Shop Drawings for the following:
 - 1. Steel framing and supports for ceiling-hung toilet compartments.
 - 2. Steel framing and supports for operable partitions.
 - 3. Steel framing and supports for overhead doors and grilles.
 - 4. Steel framing and supports for countertops.
 - 5. Steel tube reinforcement for low partitions.
 - 6. Steel framing and supports for mechanical and electrical equipment.
 - 7. Steel framing and supports for applications where framing and supports are not specified in other Sections.
 - 8. Elevator machine beams, hoist beams, and divider beams.
 - 9. Steel shapes for supporting elevator door sills.
 - 10. Shelf angles.
 - 11. Metal ladders.
 - 12. Ladder safety cages.
 - 13. Metal ships' ladders pipe crossovers.
 - 14. Metal floor plate[and supports].
 - 15. Structural-steel door frames.
 - 16. Miscellaneous steel trim including steel angle corner guards steel edgings loading-dock edge angles.
 - 17. Metal bollards.
 - 18. Pipe Downspout guards.
 - 19. Abrasive metal nosings treads and thresholds.
 - 20. Cast-iron wheel guards.
 - 21. Metal downspout boots.
 - 22. Loose steel lintels.
- C. Samples for Verification: For each type and finish of extruded .
- D. Delegated-Design Submittal: For [ladders] [and] [alternating tread devices], including analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

1.5 INFORMATIONAL SUBMITTALS

- A. Paint Compatibility Certificates: From manufacturers of topcoats applied over shop primers, certifying that shop primers are compatible with topcoats.
- B. Research/Evaluation Reports: For post-installed anchors, from ICC-ES.

1.6 QUALITY ASSURANCE

- A. Welding Qualifications: Qualify procedures and personnel according to AWS D1.1/D1.1M, "Structural Welding Code - Steel."
- B. Welding Qualifications: Qualify procedures and personnel according to the following:
 - 1. AWS D1.1/D1.1M, "Structural Welding Code - Steel."

1.7 FIELD CONDITIONS

- A. Field Measurements: Verify actual locations of walls and other construction contiguous with metal fabrications by field measurements before fabrication.

PART 2 - PRODUCTS

2.1 PERFORMANCE REQUIREMENTS

- A. Delegated Design: Engage a qualified professional engineer, as defined in Section 014000 "Quality Requirements," to design ladders.
- B. Thermal Movements: Allow for thermal movements from ambient and surface temperature changes acting on exterior metal fabrications by preventing buckling, opening of joints, overstressing of components, failure of connections, and other detrimental effects.
 - 1. Temperature Change: [120 deg F, ambient; 180 deg F, material surfaces] <Insert temperature change>.

2.2 METALS

- A. Metal Surfaces, General: Provide materials with smooth, flat surfaces unless otherwise indicated. For metal fabrications exposed to view in the completed Work, provide materials without seam marks, roller marks, rolled trade names, or blemishes.
- B. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.
- C. Rolled-Steel Floor Plate: ASTM A 786/A 786M, rolled from plate complying with ASTM A 36/A 36M or ASTM A 283/A 283M, Grade C or D.
- D. Steel Pipe: ASTM A 53/A 53M, Standard Weight (Schedule 40) unless otherwise indicated.
- E. Slotted Channel Framing: Cold-formed metal box channels (struts) complying with MFMA-4.
 - 1. Size of Channels: [1-5/8 by 1-5/8 inches] [As indicated] <Insert size>.
 - 2. Material: Galvanized steel, ASTM A 653/A 653M, [commercial steel, Type B] [structural steel, Grade 33], with G90 coating; [0.108-inch] [0.079-inch] [0.064-inch] nominal thickness.
 - 3. Material: Cold-rolled steel, ASTM A 1008/A 1008M, [commercial steel, Type B] [structural steel, Grade 33]; [0.0966-inch] [0.0677-inch] [0.0528-inch] minimum thickness;
- F. Cast Iron: Either gray iron, ASTM A 48/A 48M, or malleable iron, ASTM A 47/A 47M, unless otherwise indicated.

2.3 FASTENERS

- A. General: Unless otherwise indicated, provide [Type 304] [Type 316] stainless-steel fasteners for exterior use and zinc-plated fasteners with coating complying with ASTM B 633 or ASTM F 1941, Class Fe/Zn 5, at exterior walls. Select fasteners for type, grade, and class required.
- B. Steel Bolts and Nuts: Regular hexagon-head bolts, ASTM A 307, Grade A; with hex nuts, ASTM A 563; and, where indicated, flat washers.
- C. Steel Bolts and Nuts: Regular hexagon-head bolts, ASTM A 325, Type 3; with hex nuts, ASTM A 563, Grade C3; and, where indicated, flat washers.
- D. Stainless-Steel Bolts and Nuts: Regular hexagon-head annealed stainless-steel bolts, ASTM F 593; with hex nuts, ASTM F 594; and, where indicated, flat washers; Alloy [Group 1] [Group 2].

- E. Anchor Bolts: ASTM F 1554, Grade 36, of dimensions indicated; with nuts, ASTM A 563; and, where indicated, flat washers.
 - 1. Hot-dip galvanize or provide mechanically deposited, zinc coating where item being fastened is indicated to be galvanized.
- F. Anchors, General: Anchors capable of sustaining, without failure, a load equal to six times the load imposed when installed in unit masonry and four times the load imposed when installed in concrete, as determined by testing according to ASTM E 488/E 488M, conducted by a qualified independent testing agency.
- G. Post-Installed Anchors: Torque-controlled expansion anchors.
 - 1. Material for Interior Locations: Carbon-steel components zinc plated to comply with ASTM B 633 or ASTM F 1941, Class Fe/Zn 5, unless otherwise indicated.
- H. Slotted-Channel Inserts: Cold-formed, hot-dip galvanized-steel box channels (struts) complying with MFMA-4, 1-5/8 by 7/8 inches by length indicated with anchor straps or studs not less than 3 inches long at not more than 8 inches o.c. Provide with temporary filler and tee-head bolts, complete with washers and nuts, all zinc-plated to comply with ASTM B 633, Class Fe/Zn 5, as needed for fastening to inserts.

2.4 MISCELLANEOUS MATERIALS

- A. Shop Primers: Provide primers that comply with Section 099113 "Exterior Painting," Section 099123 Interior Painting," and Section 099600 "High-Performance Coatings."
- B. Epoxy Zinc-Rich Primer: Complying with MPI#20 and compatible with topcoat.
 - 1. Products: Subject to compliance with requirements, [provide the following] [provide one of the following] [available products that may be incorporated into the Work include, but are not limited to, the following]:
 - a. <Insert, in separate subparagraphs, manufacturer's name; product name or designation>.
- C. Shop Primer for Galvanized Steel: Primer formulated for exterior use over zinc-coated metal and compatible with finish paint systems indicated.
- D. Galvanizing Repair Paint: High-zinc-dust-content paint complying with SSPC-Paint 20 and compatible with paints specified to be used over it.
- E. Bituminous Paint: Cold-applied asphalt emulsion complying with ASTM D 1187/D 1187M.
- F. Nonshrink, Nonmetallic Grout: Factory-packaged, nonstaining, noncorrosive, nongaseous grout complying with ASTM C 1107/C 1107M. Provide grout specifically recommended by manufacturer for interior and exterior applications.

2.5 FABRICATION, GENERAL

- A. Shop Assembly: Preassemble items in the shop to greatest extent possible. Disassemble units only as necessary for shipping and handling limitations. Use connections that maintain structural value of joined pieces. Clearly mark units for reassembly and coordinated installation.
- B. Cut, drill, and punch metals cleanly and accurately. Remove burrs and ease edges to a radius of approximately 1/32 inch unless otherwise indicated. Remove sharp or rough areas on exposed surfaces.
- C. Form bent-metal corners to smallest radius possible without causing grain separation or otherwise impairing work.

- D. Form exposed work with accurate angles and surfaces and straight edges.
- E. Weld corners and seams continuously to comply with the following:
 - 1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
 - 2. Obtain fusion without undercut or overlap.
 - 3. Remove welding flux immediately.
 - 4. At exposed connections, finish exposed welds and surfaces smooth and blended so no roughness shows after finishing[and contour of welded surface matches that of adjacent surface].
- F. Form exposed connections with hairline joints, flush and smooth, using concealed fasteners or welds where possible. Where exposed fasteners are required, use Phillips flat-head (countersunk) fasteners unless otherwise indicated. Locate joints where least conspicuous.
- G. Fabricate seams and other connections that are exposed to weather in a manner to exclude water. Provide weep holes where water may accumulate.
- H. Cut, reinforce, drill, and tap metal fabrications as indicated to receive finish hardware, screws, and similar items.
- I. Provide for anchorage of type indicated; coordinate with supporting structure. Space anchoring devices to secure metal fabrications rigidly in place and to support indicated loads.
- J. Where units are indicated to be cast into concrete or built into masonry, equip with integrally welded steel strap anchors, 1/8 by 1-1/2 inches, with a minimum 6-inch embedment and 2-inch hook, not less than 8 inches from ends and corners of units and 24 inches o.c., unless otherwise indicated.

2.6 MISCELLANEOUS FRAMING AND SUPPORTS

- A. General: Provide steel framing and supports not specified in other Sections as needed to complete the Work.
- B. Fabricate units from steel shapes, plates, and bars of welded construction unless otherwise indicated. Fabricate to sizes, shapes, and profiles indicated and as necessary to receive adjacent construction.
 - 1. Fabricate units from slotted channel framing where indicated.
 - 2. Furnish inserts for units installed after concrete is placed.
- C. Fabricate supports for operable partitions from continuous steel beams of sizes [indicated] [recommended by partition manufacturer] with attached bearing plates, anchors, and braces as [indicated] [recommended by partition manufacturer]. Drill or punch bottom flanges of beams to receive partition track hanger rods; locate holes where indicated on operable partition Shop Drawings.
- D. Galvanize miscellaneous framing and supports where indicated.
- E. Prime miscellaneous framing and supports with zinc-rich primer where indicated.

2.7 SHELF ANGLES

- A. Fabricate shelf angles from steel angles of sizes indicated and for attachment to concrete framing. Provide horizontally slotted holes to receive 3/4-inch bolts, spaced not more than 6 inches from ends and 24 inches o.c., unless otherwise indicated.
 - 1. Provide mitered and welded units at corners.
 - 2. Provide open joints in shelf angles at expansion and control joints. Make open joint approximately 2 inches larger than expansion or control joint.

- B. For cavity walls, provide vertical channel brackets to support angles from backup masonry and concrete.
- C. Galvanize[and prime] shelf angles located in exterior walls.
- D. Prime shelf angles located in exterior walls with zinc-rich primer.
- E. Furnish wedge-type concrete inserts, complete with fasteners, to attach shelf angles to cast-in-place concrete.

2.8 METAL LADDERS

- A. General:
 - 1. Comply with ANSI A14.3[, except for elevator pit ladders].
 - 2. For elevator pit ladders, comply with ASME A17.1/CSA B44.
- B. Steel Ladders:
 - 1. Space siderails [16 inches] [18 inches] apart unless otherwise indicated.
 - 2. Siderails: Continuous, [3/8-by-2-1/2-inch] [1/2-by-2-1/2-inch] steel flat bars, with eased edges.
 - 3. Rungs: [3/4-inch- diameter] [3/4-inch- square] [1-inch- diameter] [1-inch- square] steel bars.
 - 4. Fit rungs in centerline of siderails; plug-weld and grind smooth on outer rail faces.
 - 5. Provide nonslip surfaces on top of each rung by coating with abrasive material metallically bonded to rung.
 - a. Products: Subject to compliance with requirements, [provide the following] [provide one of the following] [available products that may be incorporated into the Work include, but are not limited to, the following]:
 - 1) Harsco Industrial IKG, a division of Harsco Corporation; Mebac.
 - 2) SlipNOT Metal Safety Flooring, a division of W. S. Molnar Company; SlipNOT.
 - 6. Provide platforms as indicated fabricated from welded or pressure-locked steel bar grating, supported by steel angles. Limit openings in gratings to no more than [1/2 inch] [3/4 inch] in least dimension.
 - 7. Support each ladder[at top and bottom and not more than 60 inches o.c.] with welded or bolted steel brackets.
 - 8. Galvanizeexterior ladders, including brackets.
 - 9. Prime [exterior]ladders, including brackets and fasteners, with

2.9 LADDER SAFETY CAGES

- A. General:
 - 1. Fabricate ladder safety cages to comply with ANSI A14.3. Assemble by welding or with stainless-steel fasteners.
 - 2. Provide primary hoops at tops and bottoms of cages and spaced not more than 20 feet o.c. Provide secondary intermediate hoops spaced not more than 48 inches o.c. between primary hoops.
 - 3. Fasten assembled safety cage to ladder rails and adjacent construction by welding or with stainless-steel fasteners unless otherwise indicated.
- B. Steel Ladder Safety Cages:
 - 1. Primary Hoops: 1/4-by-4-inch flat bar hoops.
 - 2. Secondary Intermediate Hoops: 1/4-by-2-inch flat bar hoops.
 - 3. Vertical Bars: 3/16-by-1-1/2-inch flat bars secured to each hoop.
 - 4. Galvanize[and prime] ladder safety cages, including brackets and fasteners.

2.10 METAL SHIPS' LADDERS PIPE CROSSOVERS

- A. Provide metal ships' ladders pipe crossovers where indicated. Fabricate of open-type construction with channel or plate stringers and pipe and tube railings unless otherwise indicated. Provide brackets and fittings for installation.
 - 1. Treads shall be not less than 5 inches exclusive of nosing or less than 8-1/2 inches including the nosing, and riser height shall be not more than 9-1/2 inches.
 - 2. Fabricate ships' ladders pipe crossovers, including railings from steel.
 - 3. Fabricate treads[and platforms] from welded or pressure-locked steel bar grating. Limit openings in gratings to no more than [1/2 inch] [3/4 inch] in least dimension.
 - 4. Fabricate treads[and platforms] from .
 - 5. Comply with applicable railing requirements in Section 055213 "Pipe and Tube Railings."
- B. Galvanize[and prime] [exterior]steel ships' ladders pipe crossovers, including treads, railings, brackets, and fasteners.
- C. Prime [exterior]steel ships' ladders pipe crossovers, including treads, railings, brackets, and fasteners, with zinc-rich primer.

2.11 METAL FLOOR PLATE

- A. Fabricate from rolled-steel floor plate of thickness indicated below:
 - 1. Thickness: [1/8 inch] [3/16 inch] [1/4 inch] [5/16 inch] [3/8 inch] [As indicated].
- B. Provide grating sections where indicated fabricated from welded or pressure-locked steel bar grating. Limit openings in gratings to no more than [1/2 inch] [3/4 inch] [1 inch] in least dimension.
- C. Provide steel angle supports as indicated.
- D. Include steel angle stiffeners, and fixed and removable sections as indicated.
- E. Provide flush steel bar drop handles for lifting removable sections, one at each end of each section.

2.12 STRUCTURAL-STEEL DOOR FRAMES

- A. Fabricate structural-steel door frames from steel shapes, plates, and bars of size and to dimensions indicated, fully welded together, with 5/8-by-1-1/2-inch steel channel stops, unless otherwise indicated. Plug-weld built-up members and continuously weld exposed joints. Secure removable stops to frame with countersunk machine screws, uniformly spaced at not more than 10 inches o.c. Reinforce frames and drill and tap as necessary to accept finish hardware.
- B. Extend bottom of frames to floor elevation indicated with steel angle clips welded to frames for anchoring frame to floor with expansion shields and bolts.
- C. Galvanize exterior steel frames.
- D. Prime [exterior]steel frames with zinc-rich primer.

2.13 MISCELLANEOUS STEEL TRIM

- A. Unless otherwise indicated, fabricate units from steel shapes, plates, and bars of profiles shown with continuously welded joints and smooth exposed edges. Miter corners and use concealed field splices where possible.

- B. Provide cutouts, fittings, and anchorages as needed to coordinate assembly and installation with other work.
 - 1. Provide with integrally welded steel strap anchors for embedding in concrete or masonry construction.
- C. Galvanize[and prime] [exterior]miscellaneous steel trim.
- D. Prime [exterior]miscellaneous steel trim with zinc-rich primer.

2.14 METAL BOLLARDS

- A. Fabricate metal bollards from Schedule 80 steel pipe.
 - 1. Cap bollards with 1/4-inch- thick steel plate.
 - 2. Where bollards are indicated to receive controls for door operators, provide cutouts for controls and holes for wire.
 - 3. Where bollards are indicated to receive light fixtures, provide cutouts for fixtures and holes for wire.
- B. Fabricate sleeves for bollard anchorage from steel pipe with 1/4-inch- thick steel plate welded to bottom of sleeve. Make sleeves not less than 8 inches deep and 3/4 inch larger than OD of bollard.

2.15 PIPE DOWNSPOUT GUARDS

- A. Fabricate pipe downspout guards from 3/8-inch- thick by 12-inch- wide steel plate, bent to fit flat against the wall or column at both ends and to fit around pipe with 2-inch clearance between pipe and pipe guard. Drill each end for two 3/4-inch anchor bolts.
- B. Galvanizepipe downspout guards.
- C. Prime pipe downspout guards with zinc-rich primer.

2.16 ABRASIVE METAL TREADS THRESHOLDS

- A. Cast-Metal Units: Cast iron, with an integral-abrasive, as-cast finish consisting of aluminum oxide, silicon carbide, or a combination of both. Fabricate units in lengths necessary to accurately fit openings or conditions.
 - 1. Manufacturers: Subject to compliance with requirements, [provide products by the following] [provide products by one of the following] [available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following]:
 - a. American Safety Tread Co., Inc.
 - b. Balco, Inc.
 - c. Barry Pattern & Foundry Co., Inc.
 - d. Granite State Casting Co.
 - e. Safe-T-Metal Company, Inc.
 - f. Wooster Products Inc.
 - 2. Nosings: Cross-hatched units, 4 inches wide with [1/4-inch] [1-inch] lip, for casting into concrete.
 - 3. Nosings: Cross-hatched units, 1-1/2 by 1-1/2 inches, for casting into concrete.
 - 4. Treads: Cross-hatched units, full depth of tread with 3/4-by-3/4-inch nosing, for application over bent plate treads or existing stairs.
 - 5. Thresholds: Fluted-saddle-type units, 5 inches wide by 1/2 inch high, with tapered edges.
 - 6. Thresholds: Fluted-interlocking- (hook-strip-) type units, 5 incheswide by 5/8 inch high, with tapered edge.
 - 7. Thresholds: Plain-stepped- (stop-) type units, 5 inches wide by 1/2 inch high, with 1/2-inch step.

- B. Provide anchors for embedding units in concrete, either integral or applied to units, as standard with manufacturer.
- C. Drill for mechanical anchors and countersink. Locate holes not more than 4 inches from ends and not more than 12 inches o.c., evenly spaced between ends, unless otherwise indicated. Provide closer spacing if recommended by manufacturer.
 - 1. Provide two rows of holes for units more than 5 inches wide, with two holes aligned at ends and intermediate holes staggered.
- D. Apply bituminous paint to concealed surfaces of cast-metal units.

2.17 CAST-IRON WHEEL GUARDS

- A. Provide wheel guards made from cast-iron, 3/4-inch- thick, hollow-core construction, of size and shape indicated. Provide holes for countersunk anchor bolts and grouting.
- B. Prime cast-iron wheel guards with zinc-rich primer.

2.18 METAL DOWNSPOUT BOOTS

- A. Provide downspout boots made from cast [iron] [aluminum] in heights indicated with inlets of size and shape to suit downspouts. Provide units with flanges and holes for countersunk anchor bolts.
 - 1. Outlet: Vertical, to discharge into pipe Horizontal, to discharge into pipe At 35 degrees from horizontal, to discharge onto splash block or pavement.
- B. Prime cast-iron downspout boots with zinc-rich primer.

2.19 LOOSE BEARING AND LEVELING PLATES

- A. Provide loose bearing and leveling plates for steel items bearing on masonry or concrete construction. Drill plates to receive anchor bolts and for grouting.
- B. Galvanize plates.
- C. Prime plates with zinc-rich primer.

2.20 LOOSE STEEL LINTELS

- A. Fabricate loose steel lintels from steel angles and shapes of size indicated for openings and recesses in masonry walls and partitions at locations indicated. Fabricate in single lengths for each opening unless otherwise indicated. Weld adjoining members together to form a single unit where indicated.
- B. Galvanize[and prime] loose steel lintels located in exterior walls.
- C. Prime loose steel lintels located in exterior walls with

2.21 STEEL WELD PLATES AND ANGLES

- A. Provide steel weld plates and angles not specified in other Sections, for items supported from concrete construction as needed to complete the Work. Provide each unit with no fewer than two integrally welded steel strap anchors for embedding in concrete.

2.22 FINISHES, GENERAL

- A. Finish metal fabrications after assembly.

- B. Finish exposed surfaces to remove tool and die marks and stretch lines, and to blend into surrounding surface.

2.23 STEEL AND IRON FINISHES

- A. Galvanizing: Hot-dip galvanize items as indicated to comply with ASTM A 153/A 153M for steel and iron hardware and with ASTM A 123/A 123M for other steel and iron products.
 - 1. Do not quench or apply post galvanizing treatments that might interfere with paint adhesion.
- B. Preparation for Shop Priming Galvanized Items: After galvanizing, thoroughly clean railings of grease, dirt, oil, flux, and other foreign matter, and treat with metallic phosphate process.
- C. Shop prime iron and steel items[not indicated to be galvanized] unless they are to be embedded in concrete, sprayed-on fireproofing, or masonry, or unless otherwise indicated.
 - 1. Shop prime with universal shop primer unless zinc-rich primer is indicated.

PART 3 - EXECUTION

3.1 INSTALLATION, GENERAL

- A. Cutting, Fitting, and Placement: Perform cutting, drilling, and fitting required for installing metal fabrications. Set metal fabrications accurately in location, alignment, and elevation; with edges and surfaces level, plumb, true, and free of rack; and measured from established lines and levels.
- B. Fit exposed connections accurately together to form hairline joints. Weld connections that are not to be left as exposed joints but cannot be shop welded because of shipping size limitations. Do not weld, cut, or abrade surfaces of exterior units that have been hot-dip galvanized after fabrication and are for bolted or screwed field connections.
- C. Field Welding: Comply with the following requirements:
 - 1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
 - 2. Obtain fusion without undercut or overlap.
 - 3. Remove welding flux immediately.
 - 4. At exposed connections, finish exposed welds and surfaces smooth and blended so no roughness shows after finishing and contour of welded surface matches that of adjacent surface.
- D. Fastening to In-Place Construction: Provide anchorage devices and fasteners where metal fabrications are required to be fastened to in-place construction. Provide threaded fasteners for use with concrete and masonry inserts, toggle bolts, through bolts, lag screws, wood screws, and other connectors.
- E. Provide temporary bracing or anchors in formwork for items that are to be built into concrete, masonry, or similar construction.

3.2 INSTALLING MISCELLANEOUS FRAMING AND SUPPORTS

- A. General: Install framing and supports to comply with requirements of items being supported, including manufacturers' written instructions and requirements indicated on Shop Drawings.
- B. Anchor supports for ceiling hung toilet partitions overhead doors and overhead grilles securely to, and rigidly brace from, building structure.

3.3 INSTALLING METAL BOLLARDS

- A. Fill metal-capped bollards solidly with concrete and allow concrete to cure seven days before installing.
- B. Anchor bollards in concrete with pipe sleeves preset and anchored into concrete. Fill annular space around bollard solidly with nonshrink grout; mixed and placed to comply with grout manufacturer's written instructions. Slope grout up approximately 1/8 inch toward bollard.
- C. Place removable bollards over internal sleeves and secure with 3/4-inch machine bolts and nuts. After tightening nuts, drill holes in bolts for inserting padlocks. Owner furnishes padlocks.
- D. Fill bollards solidly with concrete, mounding top surface to shed water.
 - 1. Do not fill removable bollards with concrete.

3.4 INSTALLING PIPE GUARDS

- A. Provide pipe guards at exposed vertical pipes in parking garage where not protected by curbs or other barriers. Install by bolting to wall or column with expansion anchors. Provide four 3/4-inch bolts at each pipe guard. Mount pipe guards with top edge 26 inches above driving surface.

3.5 INSTALLING NOSINGS, TREADS, AND THRESHOLDS

- A. Center nosings on tread widths unless otherwise indicated.
- B. For nosings embedded in concrete steps or curbs, align nosings flush with riser faces and level with tread surfaces.
- C. Seal thresholds exposed to exterior with elastomeric sealant complying with Section 079200 "Joint Sealants" to provide a watertight installation.

3.6 INSTALLING CAST-IRON WHEEL GUARDS

- A. Anchor wheel guards to concrete or masonry construction to comply with manufacturer's written instructions. Fill cores solidly with concrete.

3.7 INSTALLING BEARING AND LEVELING PLATES

- A. Clean concrete and masonry bearing surfaces of bond-reducing materials, and roughen to improve bond to surfaces. Clean bottom surface of plates.
- B. Set bearing and leveling plates on wedges, shims, or leveling nuts. After bearing members have been positioned and plumbed, tighten anchor bolts. Do not remove wedges or shims but, if protruding, cut off flush with edge of bearing plate before packing with nonshrink grout. Pack grout solidly between bearing surfaces and plates to ensure that no voids remain.

3.8 ADJUSTING AND CLEANING

- A. Touchup Painting: Immediately after erection, clean field welds, bolted connections, and abraded areas. Paint uncoated and abraded areas with the same material as used for shop painting to comply with SSPC-PA 1 for touching up shop-painted surfaces.
 - 1. Apply by brush or spray to provide a minimum 2.0-mil dry film thickness.
- B. Touchup Painting: Cleaning and touchup painting of field welds, bolted connections, and abraded areas of shop paint are specified in [Section 099113 "Exterior Painting."] [Section 099123 "Interior Painting."]

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METAL FABRICATIONS

- C. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas and repair galvanizing to comply with ASTM A 780/A 780M.

END OF SECTION 055000

SECTION 055113

METAL PAN STAIRS

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section Includes:
 - 1. Preassembled steel stairs with concrete-filled treads.
 - 2. [Steel tube]railings attached to metal stairs.
 - 3. [Steel tube]handrails attached to walls adjacent to metal stairs.

1.3 COORDINATION

- A. Coordinate selection of shop primers with topcoats to be applied over them. Comply with paint and coating manufacturers' written recommendations to ensure that shop primers and topcoats are compatible with one another.
- B. Coordinate installation of anchorages for metal stairs. Furnish setting drawings, templates, and directions for installing anchorages, including sleeves, concrete inserts, anchor bolts, and items with integral anchors, that are to be embedded in concrete or masonry. Deliver such items to Project site in time for installation.
- C. Coordinate locations of hanger rods and struts with other work so that they do not encroach on required stair width and are within the fire-resistance-rated stair enclosure.

1.4 ACTION SUBMITTALS

- A. Product Data: For metal pan stairs and the following:
 - 1. Prefilled metal-pan-stair treads.
 - 2. Precast concrete treads.
 - 3. Nonslip aggregates and nonslip-aggregate finishes.
 - 4. Abrasive nosings.
 - 5. Paint products.
- B. Shop Drawings: Include plans, elevations, sections, details, and attachments to other work.
- C. Samples for Verification: For each type and finish of [nosing] [and] [tread].
- D. Delegated-Design Submittal: For stairs[and railings], including analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

1.5 INFORMATIONAL SUBMITTALS

- A. Paint Compatibility Certificates: From manufacturers of topcoats applied over shop primers certifying that shop primers are compatible with topcoats.

1.6 QUALITY ASSURANCE

- A. Installer Qualifications: Fabricator of products.
- B. Welding Qualifications: Qualify procedures and personnel according to the following:

1. AWS D1.1/D1.1M, "Structural Welding Code - Steel."

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Manufacturers: Subject to compliance with requirements, [provide products by the following] [provide products by one of the following] [available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following]:
- B. Basis-of-Design Product: Subject to compliance with requirements, provide [product indicated on Drawings] <Insert manufacturer's name; product name or designation> or comparable product by one of the following:
 1. Alfab, Inc.
 2. American Stair, Inc.
 3. Lapeyre Stair Inc.
 4. Worthington Metal Fabricators.

2.2 PERFORMANCE REQUIREMENTS

- A. Delegated Design: Engage a qualified professional engineer, as defined in Section 014000 "Quality Requirements," to design stairs[and railings].
- B. Structural Performance of Stairs: Metal stairs shall withstand the effects of gravity loads and the following loads and stresses within limits and under conditions indicated:
 1. Uniform Load: 100 lbf/sq. ft..
 2. Concentrated Load: 300 lbf applied on an area of 4 sq. in..
 3. Uniform and concentrated loads need not be assumed to act concurrently.
 4. Stair Framing: Capable of withstanding stresses resulting from railing loads in addition to loads specified above.
 5. Limit deflection of treads, platforms, and framing members to [L/360] <Insert deflection ratio> or 1/4 inch, whichever is less.
- C. Structural Performance of Railings: Railings shall withstand the effects of gravity loads and the following loads and stresses within limits and under conditions indicated:
 1. Handrails and Top Rails of Guards:
 - a. Uniform load of 50 lbf/ft. applied in any direction.
 - b. Concentrated load of 200 lbf applied in any direction.
 - c. Uniform and concentrated loads need not be assumed to act concurrently.
 2. Infill of Guards:
 - a. Concentrated load of 50 lbf applied horizontally on an area of 1 sq. ft..
 - b. Infill load and other loads need not be assumed to act concurrently.
- D. Seismic Performance of Stairs: Metal stairs shall withstand the effects of earthquake motions determined according to [ASCE/SEI 7] <Insert requirement>.
 1. Component Importance Factor: 1.5.

2.3 METALS

- A. Metal Surfaces, General: Provide materials with smooth, flat surfaces unless otherwise indicated. For components exposed to view in the completed Work, provide materials without seam marks, roller marks, rolled trade names, or blemishes.
- B. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.
- C. Steel Tubing: [ASTM A 500 (cold formed)] [or] [ASTM A 513].

- D. Cast Iron: Either gray iron, ASTM A 48/A 48M, or malleable iron, ASTM A 47/A 47M, unless otherwise indicated.
- E. Uncoated, Cold-Rolled Steel Sheet: ASTM A 1008/A 1008M, [either commercial steel, Type B, or] structural steel, Grade 25, unless another grade is required by design loads; exposed.
- F. Woven-Wire Mesh: Intermediate-crimp, [diamond] [square] pattern, 2-inch woven-wire mesh, made from 0.135-inch nominal diameter wire complying with ASTM A 510.

2.4 ABRASIVE NOSINGS

- A. Cast-Metal Units: Cast iron, with an integral abrasive, as-cast finish consisting of aluminum oxide, silicon carbide, or a combination of both. Fabricate units in lengths necessary to accurately fit openings or conditions.
 - 1. Manufacturers: Subject to compliance with requirements, [provide products by the following] [provide products by one of the following] [available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following]:
 - 2. Basis-of-Design Product: Subject to compliance with requirements, provide [product indicated on Drawings] <Insert manufacturer's name; product name or designation> or comparable product by one of the following:
 - a. American Safety Tread Co., Inc.
 - b. Balco, Inc.
 - c. Barry Pattern & Foundry Co., Inc.
 - d. Granite State Casting Co.
 - e. Safe-T-Metal Company, Inc.
 - f. Wooster Products Inc.
 - 3. Configuration: Cross-hatched units, [3 inches] [4 inches] wide without lip.
- B. Provide anchors for embedding units in concrete, either integral or applied to units, as standard with manufacturer.
- C. Apply clear lacquer to concealed surfaces of extruded units set into concrete.

2.5 FASTENERS

- A. General: Provide zinc-plated fasteners with coating complying with ASTM B 633 or ASTM F 1941, Class Fe/Zn 12 for exterior use, and Class Fe/Zn 5 where built into exterior walls. Select fasteners for type, grade, and class required.
- B. Post-Installed Anchors: Torque-controlled expansion anchors capable of sustaining, without failure, a load equal to six times the load imposed when installed in unit masonry and four times the load imposed when installed in concrete, as determined by testing according to ASTM E 488/E 488M, conducted by a qualified independent testing agency.
 - 1. Material for Interior Locations: Carbon-steel components zinc plated to comply with ASTM B 633 or ASTM F 1941, Class Fe/Zn 5, unless otherwise indicated.
 - 2. Material for Exterior Locations and Where Stainless Steel Is Indicated: Alloy [Group 1] [Group 2] stainless-steel bolts, ASTM F 593, and nuts, ASTM F 594.

2.6 MISCELLANEOUS MATERIALS

- A. Shop Primers: Provide primers that comply with Section 099113 "Exterior Painting," Section 099123 "Interior Painting," and Section 099600 "High-Performance Coatings."
- B. Universal Shop Primer: Fast-curing, lead- and chromate-free, universal modified-alkyd primer complying with MPI#79 and compatible with topcoat.
 - 1. Use primer containing pigments that make it easily distinguishable from zinc-rich primer.

- C. Galvanizing Repair Paint: High-zinc-dust-content paint complying with SSPC-Paint 20 and compatible with paints specified to be used over it.
- D. Concrete Materials and Properties: Comply with requirements in Section 033000 "Cast-in-Place Concrete" for normal-weight, air-entrained, ready-mix concrete with a minimum 28-day compressive strength of 3000 psi unless otherwise indicated.
- E. Nonslip-Aggregate Concrete Finish: Factory-packaged abrasive aggregate made from fused, aluminum-oxide grits or crushed emery; rustproof and nonglazing; unaffected by freezing, moisture, or cleaning materials.
- F. Welded Wire Reinforcement: ASTM A 185/A 185M, 6 by 6 inches, W1.4 by W1.4, unless otherwise indicated.

2.7 FABRICATION, GENERAL

- A. Provide complete stair assemblies, including metal framing, hangers, struts,[railings,] clips, brackets, bearing plates, and other components necessary to support and anchor stairs and platforms on supporting structure.
 - 1. Join components by welding unless otherwise indicated.
 - 2. Use connections that maintain structural value of joined pieces.
- B. Preassembled Stairs: Assemble stairs in shop to greatest extent possible. Disassemble units only as necessary for shipping and handling limitations. Clearly mark units for reassembly and coordinated installation.
- C. Cut, drill, and punch metals cleanly and accurately. Remove burrs and ease edges to a radius of approximately 1/32 inch unless otherwise indicated. Remove sharp or rough areas on exposed surfaces.
- D. Form bent-metal corners to smallest radius possible without causing grain separation or otherwise impairing work.
- E. Form exposed work with accurate angles and surfaces and straight edges.
- F. Weld connections to comply with the following:
 - 1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
 - 2. Obtain fusion without undercut or overlap.
 - 3. Remove welding flux immediately.
 - 4. Weld exposed corners and seams continuously unless otherwise indicated.
 - 5. At exposed connections, finish exposed welds to comply with NOMMA's "Voluntary Joint Finish Standards" for [Type 3 welds: partially dressed weld with spatter removed] [Type 4 welds: good quality, uniform undressed weld with minimal splatter].
- G. Form exposed connections with hairline joints, flush and smooth, using concealed fasteners where possible. Where exposed fasteners are required, use Phillips flat-head (countersunk) screws or bolts unless otherwise indicated. Locate joints where least conspicuous.

2.8 STEEL-FRAMED STAIRS

- A. Stair Framing:
 - 1. Fabricate stringers of steel plates.
 - 2. Construct platforms of steel plate headers and miscellaneous framing members as [needed to comply with performance requirements] [indicated].
 - 3. Weld[or bolt] stringers to headers; weld[or bolt] framing members to stringers and headers.[If using bolts, fabricate and join so bolts are not exposed on finished surfaces.]

4. Where stairs are enclosed by gypsum board[shaft-wall] assemblies, provide hanger rods or struts to support landings from floor construction above or below. Locate hanger rods and struts where they do not encroach on required stair width and are within the fire-resistance-rated stair enclosure.
 5. Where masonry walls support metal stairs, provide temporary supporting struts designed for erecting steel stair components before installing masonry.
- B. Metal Pan Stairs: Form risers, subreads pans, and subplatforms to configurations shown from steel sheet of thickness [needed to comply with performance requirements, but not less than 0.067 inch] [indicated].
1. Directly weld metal pans to stringers; locate welds on top of subreads where they are concealed by concrete fill. Do not weld risers to stringers.
 2. Shape metal pans to include nosing integral with riser.
 3. Attach abrasive nosings to risers.
 4. At Contractor's option, provide stair assemblies with metal pan subreads filled with reinforced concrete during fabrication.
 5. Provide subplatforms of configuration indicated or, if not indicated, the same as subreads. Weld subplatforms to platform framing.
 - a. Smooth Soffit Construction: Construct subplatforms with flat metal under surfaces to produce smooth soffits.

2.9 STAIR RAILINGS

- A. Comply with applicable requirements in
1. Fabricate newels of square steel tubing and provide newel caps of [pressed steel] [gray-iron castings], as shown.
 2. Rails may be bent at corners, rail returns, and wall returns, instead of using prefabricated fittings.
 3. Connect posts to stair framing by direct welding unless otherwise indicated.
- B. Steel Tube Railings: Fabricate railings to comply with requirements indicated for design, dimensions, details, finish, and member sizes, including wall thickness of tube, post spacings, and anchorage, but not less than that needed to withstand indicated loads.
1. Rails and Posts: 1-1/2-inch-square top and bottom rails and 1-1/2-inch- square posts.
 2. Mesh Infill: Woven wire mesh crimped into 1-by-1/2-by-1/8-inch steel channel frames. Orient wire mesh with [diamonds vertical] [wires perpendicular and parallel to top rail] [wires horizontal and vertical].
- C. Welded Connections: Fabricate railings with welded connections. Cope components at connections to provide close fit, or use fittings designed for this purpose. Weld all around at connections, including at fittings.
1. Finish welds to comply with NOMMA's "Voluntary Joint Finish Standards" for [Type 1 welds: no evidence of a welded joint] [Type 2 welds: completely sanded joint, some undercutting and pinholes are okay] [Type 3 welds: partially dressed weld with spatter removed] [Type 4 welds: good quality, uniform undressed weld with minimal splatter] as shown in NAAMM AMP 521.
- D. Form changes in direction of railings as follows:
1. By bending.
 2. By flush bends or by inserting prefabricated flush-elbow fittings.
 3. By inserting prefabricated flush-elbow fittings.
- E. For changes in direction made by bending, use jigs to produce uniform curvature for each repetitive configuration required. Maintain cross section of member throughout entire bend without buckling, twisting, cracking, or otherwise deforming exposed surfaces of components.
- F. Close exposed ends of railing members with prefabricated end fittings.

- G. Provide wall returns at ends of wall-mounted handrails unless otherwise indicated. Close ends of returns unless clearance between end of rail and wall is 1/4 inch or less.
- H. Connect posts to stair framing by direct welding unless otherwise indicated.
- I. Brackets, Flanges, Fittings, and Anchors: Provide wall brackets, end closures, flanges, miscellaneous fittings, and anchors for interconnecting components and for attaching to other work. Furnish inserts and other anchorage devices for connecting to concrete or masonry work.
 - 1. For galvanized railings, provide galvanized fittings, brackets, fasteners, sleeves, and other ferrous-metal components.
 - 2. For nongalvanized railings, provide nongalvanized ferrous-metal fittings, brackets, fasteners, and sleeves, except galvanize anchors embedded in exterior masonry and concrete construction.
 - 3. Provide type of bracket [with flange tapped for concealed anchorage to threaded hanger bolt] [with predrilled hole for exposed bolt anchorage] and that provides 1-1/2-inch clearance from inside face of handrail to finished wall surface.

2.10 FINISHES

- A. Finish metal stairs after assembly.
- B. Preparation for Shop Priming: Prepare uncoated ferrous-metal surfaces to comply with SSPC-SP 3, "Power Tool Cleaning."
- C. Apply shop primer to uncoated surfaces of metal stair components, except those with galvanized finishes and those to be embedded in concrete or masonry unless otherwise indicated. Comply with SSPC-PA 1, "Paint Application Specification No. 1: Shop, Field, and Maintenance Painting of Steel," for shop painting.

PART 3 - EXECUTION

3.1 INSTALLING METAL PAN STAIRS

- A. Fastening to In-Place Construction: Provide anchorage devices and fasteners where necessary for securing metal stairs to in-place construction. Include threaded fasteners for concrete and masonry inserts, through-bolts, lag bolts, and other connectors.
- B. Cutting, Fitting, and Placement: Perform cutting, drilling, and fitting required for installing metal stairs. Set units accurately in location, alignment, and elevation, measured from established lines and levels and free of rack.
- C. Install metal stairs by welding stair framing to steel structure or to weld plates cast into concrete unless otherwise indicated.
- D. Provide temporary bracing or anchors in formwork for items that are to be built into concrete, masonry, or similar construction.
- E. Fit exposed connections accurately together to form hairline joints. Weld connections that are not to be left as exposed joints but cannot be shop welded because of shipping size limitations. Do not weld, cut, or abrade surfaces of exterior units that have been hot-dip galvanized after fabrication and are for bolted or screwed field connections.
- F. Field Welding: Comply with requirements for welding in "Fabrication, General" Article.
- G. Place and finish concrete fill for treads and platforms to comply with Section 033000 "Cast-in-Place Concrete."

1. Install abrasive nosings with anchors fully embedded in concrete. Center nosings on tread width.

3.2 INSTALLING RAILINGS

- A. Adjust railing systems before anchoring to ensure matching alignment at abutting joints. Space posts at spacing indicated or, if not indicated, as required by design loads. Plumb posts in each direction. Secure posts and rail ends to building construction as follows:
 1. Anchor posts to steel by [welding] [or] [bolting] to steel supporting members.
 2. Anchor handrail ends to concrete and masonry with steel round flanges welded to rail ends and anchored with postinstalled anchors and bolts.
- B. Attach handrails to wall with wall brackets. Locate brackets as indicated or, if not indicated, at spacing required to support structural loads. Secure wall brackets to building construction[as required to comply with performance requirements.][as follows:]
 1. For concrete and solid masonry anchorage, use drilled-in expansion shields and hanger or lag bolts.
 2. For hollow masonry anchorage, use toggle bolts.
 3. For wood stud partitions, use hanger or lag bolts set into studs or wood backing between studs. Coordinate with carpentry work to locate backing members.
 4. For steel-framed partitions, use hanger or lag bolts set into [fire-retardant-treated] wood backing between studs. Coordinate with stud installation to locate backing members.
 5. For steel-framed partitions, use self-tapping screws fastened to steel framing or to concealed steel reinforcements.
 6. For steel-framed partitions, use toggle bolts installed through flanges of steel framing or through concealed steel reinforcements.

3.3 ADJUSTING AND CLEANING

- A. Touchup Painting: Immediately after erection, clean field welds, bolted connections, and abraded areas of shop paint, and paint exposed areas with same material as used for shop painting to comply with SSPC-PA 1 for touching up shop-painted surfaces.
 1. Apply by brush or spray to provide a minimum 2.0-mil dry film thickness.
- B. Touchup Painting: Cleaning and touchup painting of field welds, bolted connections, and abraded areas of shop paint are specified in [Section 099113 "Exterior Painting" and Section 099123 "Interior Painting."] [Section 099600 "High-Performance Coatings."] [Section 099113 "Exterior Painting," Section 099123 "Interior Painting," and Section 099600 "High-Performance Coatings."]
- C. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas and repair galvanizing to comply with ASTM A 780/A 780M.

END OF SECTION 055113

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SECTION 055213

PIPE AND TUBE RAILINGS

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section Includes:
 - 1. Steel pipe tube railings.
 - 2. Stainless-steel pipe tube railings.

1.3 COORDINATION

- A. Coordinate selection of shop primers with topcoats to be applied over them. Comply with paint and coating manufacturers' written recommendations to ensure that shop primers and topcoats are compatible with one another.
- B. Coordinate installation of anchorages for railings. Furnish setting drawings, templates, and directions for installing anchorages, including sleeves, concrete inserts, anchor bolts, and items with integral anchors, that are to be embedded in concrete or masonry. Deliver such items to Project site in time for installation.
- C. Schedule installation so wall attachments are made only to completed walls. Do not support railings temporarily by any means that do not satisfy structural performance requirements.

1.4 ACTION SUBMITTALS

- A. Product Data: For the following:
 - 1. Manufacturer's product lines of mechanically connected railings.
 - 2. Railing brackets.
 - 3. Grout, anchoring cement, and paint products.
- B. Shop Drawings: Include plans, elevations, sections, details, and attachments to other work.
- C. Samples: For each type of exposed finish required.
 - 1. Sections of each distinctly different linear railing member, including handrails, top rails, posts, and balusters.
 - 2. Fittings and brackets.
 - 3. Assembled Sample of railing system, made from full-size components, including top rail, post, handrail, and infill. Sample need not be full height.
 - a. Show method of [connecting] [and] [finishing] members at intersections.
- D. Delegated-Design Submittal: For railings, including analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

1.5 INFORMATIONAL SUBMITTALS

- A. Qualification Data: For testing agency.
- B. Welding certificates.

- C. Mill Certificates: Signed by manufacturers of stainless-steel products certifying that products furnished comply with requirements.
- D. Paint Compatibility Certificates: From manufacturers of topcoats applied over shop primers certifying that shop primers are compatible with topcoats.
- E. Product Test Reports: For pipe and tube railings, for tests performed by a qualified testing agency, according to ASTM E 894 and ASTM E 935.

1.6 QUALITY ASSURANCE

- A. Welding Qualifications: Qualify procedures and personnel according to the following:
 - 1. AWS D1.1/D1.1M, "Structural Welding Code - Steel."
 - 2. AWS D1.6/D1.6M, "Structural Welding Code - Stainless Steel."

1.7 DELIVERY, STORAGE, AND HANDLING

- A. Protect mechanical finishes on exposed surfaces from damage by applying a strippable, temporary protective covering before shipping.

1.8 FIELD CONDITIONS

- A. Field Measurements: Verify actual locations of walls and other construction contiguous with metal fabrications by field measurements before fabrication.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Steel Pipe and Tube Railings:
 - 1. Manufacturers: Subject to compliance with requirements, [provide products by the following] [provide products by one of the following] [available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following]:
 - 2. Basis-of-Design Product: Subject to compliance with requirements, provide [product indicated on Drawings] <Insert manufacturer's name; product name or designation> or comparable product by one of the following:
 - a. Wagner, R & B, Inc.
- B. Stainless-Steel Pipe and Tube Railings:
 - 1. Manufacturers: Subject to compliance with requirements, [provide products by the following] [provide products by one of the following] [available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following]:
 - 2. Basis-of-Design Product: Subject to compliance with requirements, provide [product indicated on Drawings] <Insert manufacturer's name; product name or designation> or comparable product by one of the following:
 - a. Blum, Julius & Co., Inc.
 - b. Stainless Fabricators, Inc.
 - c. Sterling Dula Architectural Products, Inc; Div. of Kane Manufacturing..
 - d. Tri Tech, Inc.
 - e. Tubular Specialties Manufacturing, Inc.
 - f. Tuttle Railing Systems.
 - g. Wagner, R & B, Inc.
- C. Source Limitations: Obtain each type of railing from single source from single manufacturer.

2.2 PERFORMANCE REQUIREMENTS

- A. Delegated Design: Engage a qualified professional engineer, as defined in Section 014000 "Quality Requirements," to design railings, including attachment to building construction.
- B. Structural Performance: Railings, including attachment to building construction, shall withstand the effects of gravity loads and the following loads and stresses within limits and under conditions indicated:
 - 1. Handrails and Top Rails of Guards:
 - a. Uniform load of 50 lbf/ ft. applied in any direction.
 - b. Concentrated load of 200 lbf applied in any direction.
 - c. Uniform and concentrated loads need not be assumed to act concurrently.
 - 2. Infill of Guards:
 - a. Concentrated load of 50 lbf applied horizontally on an area of 1 sq. ft..
 - b. Infill load and other loads need not be assumed to act concurrently.

2.3 METALS, GENERAL

- A. Metal Surfaces, General: Provide materials with smooth surfaces, without seam marks, roller marks, rolled trade names, stains, discolorations, or blemishes.
- B. Brackets, Flanges, and Anchors: Cast or formed metal of same type of material and finish as supported rails unless otherwise indicated.
 - 1. Provide type of bracket with [flange tapped for concealed anchorage to threaded hanger bolt] [predrilled hole for exposed bolt anchorage] and that provides 1-1/2-inch clearance from inside face of handrail to finished wall surface.

2.4 STEEL AND IRON

- A. Tubing: [ASTM A 500 (cold formed)] [or] [ASTM A 513].
- B. Pipe: ASTM A 53/A 53M, Type F or Type S, Grade A, Standard Weight (Schedule 40), unless another grade and weight are required by structural loads.
 - 1. Provide galvanized finish for exterior installations and where indicated.

2.5 STAINLESS STEEL

- A. Tubing: ASTM A 554, Grade MT 304 Grade MT 316L.
- B. Pipe: ASTM A 312/A 312M, Grade TP 304 Grade TP 316L.

2.6 FASTENERS

- A. General: Provide the following:
 - 1. Ungalvanized-Steel Railings: Plated steel fasteners complying with ASTM B 633 or ASTM F 1941, Class Fe/Zn 5 for zinc coating.
 - 2. Hot-Dip Galvanized Railings: Type 304 stainless-steel or hot-dip zinc-coated steel fasteners complying with ASTM A 153/A 153M or ASTM F 2329 for zinc coating.
 - 3. Stainless-Steel Railings: [Type 304] [Type 316] stainless-steel fasteners.
 - 4. Provide exposed fasteners with finish matching appearance, including color and texture, of railings.
- B. Fasteners for Anchoring Railings to Other Construction: Select fasteners of type, grade, and class required to produce connections suitable for anchoring railings to other types of construction indicated[and capable of withstanding design loads].
- C. Fasteners for Interconnecting Railing Components:

1. Provide concealed fasteners for interconnecting railing components and for attaching them to other work, unless otherwise indicated.
 2. Provide concealed fasteners for interconnecting railing components and for attaching them to other work, unless exposed fasteners are unavoidable or are the standard fastening method for railings indicated.
 3. Provide [Phillips] [tamper-resistant] [square or hex socket] flat-head machine screws for exposed fasteners unless otherwise indicated.
- D. Post-Installed Anchors: [Torque-controlled expansion anchors] [or] [chemical anchors] capable of sustaining, without failure, a load equal to 6 times the load imposed when installed in unit masonry and 4 times the load imposed when installed in concrete, as determined by testing according to ASTM E 488/E 488M, conducted by a qualified independent testing agency.
1. Material for Interior Locations: Carbon-steel components zinc-plated to comply with ASTM B 633 or ASTM F 1941, Class Fe/Zn 5, unless otherwise indicated.
 2. Material for Exterior Locations and Where Stainless Steel Is Indicated: Alloy [Group 1] [Group 2] stainless-steel bolts, ASTM F 593, and nuts, ASTM F 594.

2.7 MISCELLANEOUS MATERIALS

- A. Etching Cleaner for Galvanized Metal: Complying with MPI#25.
- B. Galvanizing Repair Paint: High-zinc-dust-content paint complying with SSPC-Paint 20 and compatible with paints specified to be used over it.
- C. Shop Primers: Provide primers that comply with [Section 099113 "Exterior Painting" and Section 099123 "Interior Painting."] [Section 099600 "High-Performance Coatings."] [Section 099113 "Exterior Painting,"Section 099123 "Interior Painting," and Section 099600 "High-Performance Coatings."]
- D. Epoxy Zinc-Rich Primer: Complying with MPI#20 and compatible with topcoat.
1. Manufacturers: Subject to compliance with requirements, [provide products by the following] [provide products by one of the following] [available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following]:
 2. Basis-of-Design Product: Subject to compliance with requirements, provide [product indicated on Drawings] <Insert manufacturer's name; product name or designation> or comparable product by one of the following:
 - a. <Insert, in separate subparagraphs, manufacturer's name>.
- E. Shop Primer for Galvanized Steel: Primer formulated for exterior use over zinc-coated metal and compatible with finish paint systems indicated.
- F. Intermediate Coats and Topcoats: Provide products that comply with [Section 099113 "Exterior Painting" and Section 099123 "Interior Painting."] [Section 099600 "High-Performance Coatings."] [Section 099113 "Exterior Painting,"Section 099123 "Interior Painting,"and Section 099600 "High-Performance Coatings."]
- G. Epoxy Intermediate Coat: Complying with MPI #77 and compatible with primer and topcoat.
1. Manufacturers: Subject to compliance with requirements, [provide products by the following] [provide products by one of the following] [available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following]:
 2. Basis-of-Design Product: Subject to compliance with requirements, provide [product indicated on Drawings] <Insert manufacturer's name; product name or designation> or comparable product by one of the following:
 - a. <Insert, in separate subparagraphs, manufacturer's name>.
- H. Polyurethane Topcoat: Complying with MPI #72 and compatible with undercoat.

1. Manufacturers: Subject to compliance with requirements, [provide products by the following] [provide products by one of the following] [available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following]:
 2. Basis-of-Design Product: Subject to compliance with requirements, provide [product indicated on Drawings] <Insert manufacturer's name; product name or designation> or comparable product by one of the following:
 - a. <Insert, in separate subparagraphs, manufacturer's name>.
- I. Bituminous Paint: Cold-applied asphalt emulsion complying with ASTM D 1187/D 1187M.
- J. Nonshrink, Nonmetallic Grout: Factory-packaged, nonstaining, noncorrosive, nongaseous grout complying with ASTM C 1107/C 1107M. Provide grout specifically recommended by manufacturer for interior and exterior applications.
- K. Anchoring Cement: Factory-packaged, nonshrink, nonstaining, hydraulic-controlled expansion cement formulation for mixing with water at Project site to create pourable anchoring, patching, and grouting compound.
1. Water-Resistant Product: where indicated provide formulation that is resistant to erosion from water exposure without needing protection by a sealer or waterproof coating and that is recommended by manufacturer for exterior use.

2.8 FABRICATION

- A. General: Fabricate railings to comply with requirements indicated for design, dimensions, member sizes and spacing, details, finish, and anchorage[, but not less than that required to support structural loads].
- B. Shop assemble railings to greatest extent possible to minimize field splicing and assembly. Disassemble units only as necessary for shipping and handling limitations. Clearly mark units for reassembly and coordinated installation. Use connections that maintain structural value of joined pieces.
- C. Cut, drill, and punch metals cleanly and accurately. Remove burrs and ease edges to a radius of approximately 1/32 inch unless otherwise indicated. Remove sharp or rough areas on exposed surfaces.
- D. Form work true to line and level with accurate angles and surfaces.
- E. Fabricate connections that are exposed to weather in a manner that excludes water. Provide weep holes where water may accumulate.
- F. Cut, reinforce, drill, and tap as indicated to receive finish hardware, screws, and similar items.
- G. Connections: Fabricate railings with either welded or nonwelded connections unless otherwise indicated.
- H. Welded Connections: Cope components at connections to provide close fit, or use fittings designed for this purpose. Weld all around at connections, including at fittings.
1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
 2. Obtain fusion without undercut or overlap.
 3. Remove flux immediately.
 4. At exposed connections, finish exposed surfaces smooth and blended so no roughness shows after finishing and welded surface matches contours of adjoining surfaces.

- I. Welded Connections for Aluminum Pipe: Fabricate railings to interconnect members with concealed internal welds that eliminate surface grinding, using manufacturer's standard system of sleeve and socket fittings.
- J. Nonwelded Connections: Connect members with concealed mechanical fasteners and fittings. Fabricate members and fittings to produce flush, smooth, rigid, hairline joints.
 - 1. Fabricate splice joints for field connection using an epoxy structural adhesive if this is manufacturer's standard splicing method.
- K. Form Changes in Direction as Follows:
 - 1. As detailed.
 - 2. By bending.
 - 3. By flush bends.
 - 4. By radius bends of radius indicated.
- L. For changes in direction made by bending, use jigs to produce uniform curvature for each repetitive configuration required. Maintain cross section of member throughout entire bend without buckling, twisting, cracking, or otherwise deforming exposed surfaces of components.
- M. Close exposed ends of railing members with prefabricated end fittings.
- N. Provide wall returns at ends of wall-mounted handrails unless otherwise indicated. Close ends of returns unless clearance between end of rail and wall is 1/4 inch or less.
- O. Brackets, Flanges, Fittings, and Anchors: Provide wall brackets, flanges, miscellaneous fittings, and anchors to interconnect railing members to other work unless otherwise indicated.
 - 1. At brackets and fittings fastened to plaster or gypsum board partitions, provide crush-resistant fillers or other means to transfer loads through wall finishes to structural supports and prevent bracket or fitting rotation and crushing of substrate.
- P. Provide inserts and other anchorage devices for connecting railings to concrete or masonry work. Fabricate anchorage devices capable of withstanding loads imposed by railings. Coordinate anchorage devices with supporting structure.
- Q. For railing posts set in concrete, provide [steel] [stainless-steel] sleeves not less than 6 inches long with inside dimensions not less than 1/2 inch greater than outside dimensions of post, with metal plate forming bottom closure.
- R. Perforated-Metal Infill Panels: Fabricate infill panels from perforated metal made from [steel] [galvanized steel] [aluminum] [stainless steel] [same metal as railings in which they are installed].
 - 1. Edge panels with U-shaped channels made from metal sheet, of same metal as perforated metal and not less than 0.043 inch thick.
 - 2. Orient perforated metal with pattern [parallel to top rail] [perpendicular to top rail] [horizontal] [vertical] [as indicated on Drawings].
- S. Toe Boards: Where indicated, provide toe boards at railings around openings and at edge of open-sided floors and platforms. Fabricate to dimensions and details indicated.

2.9 STEEL AND IRON FINISHES

- A. Galvanized Railings:
 - 1. Hot-dip galvanize indicated steel railings, including hardware, after fabrication.
 - 2. Comply with ASTM A 123/A 123M for hot-dip galvanized railings.
 - 3. Comply with ASTM A 153/A 153M for hot-dip galvanized hardware.
 - 4. Do not quench or apply post galvanizing treatments that might interfere with paint adhesion.

5. Fill vent and drain holes that are exposed in the finished Work, unless indicated to remain as weep holes, by plugging with zinc solder and filing off smooth.
- B. For galvanized railings, provide hot-dip galvanized fittings, brackets, fasteners, sleeves, and other ferrous components.
- C. Preparing Galvanized Railings for Shop Priming: After galvanizing, thoroughly clean railings of grease, dirt, oil, flux, and other foreign matter, and treat with etching cleaner.
- D. For nongalvanized-steel railings, provide nongalvanized ferrous-metal fittings, brackets, fasteners, and sleeves; however, galvanize anchors to be embedded in exterior concrete or masonry.
- E. Preparation for Shop Priming: Prepare uncoated ferrous-metal surfaces to comply with [SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."] [SSPC-SP 3, "Power Tool Cleaning."] [requirements indicated below:]
 1. Railings Indicated to Receive Zinc-Rich Primer: SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
 2. Railings Indicated to Receive Primers Specified in Section 099600 "High-Performance Coatings": SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
 3. Other Railings: SSPC-SP 3, "Power Tool Cleaning."
- F. Primer Application: Apply shop primer to prepared surfaces of railings unless otherwise indicated. Comply with requirements in SSPC-PA 1, "Shop, Field, and Maintenance Painting of Steel," for shop painting. Primer need not be applied to surfaces to be embedded in concrete or masonry.
 1. Shop prime uncoated railings with unless zinc-rich primer is indicated.
 2. Do not apply primer to galvanized surfaces.
- G. Shop-Painted Finish: Comply with Section 099113 "Exterior Painting."
 1. Color: [As indicated by manufacturer's designations] [Match Architect's sample] [As selected by Architect from manufacturer's full range].

2.10 STAINLESS-STEEL FINISHES

- A. Remove tool and die marks and stretch lines, or blend into finish.
- B. Grind and polish surfaces to produce uniform, directionally textured, polished finish indicated, free of cross scratches.[Run grain with long dimension of each piece.]
- C. Directional Satin Finish: No. 4.
- D. When polishing is completed, passivate and rinse surfaces. Remove embedded foreign matter and leave surfaces chemically clean.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine plaster and gypsum board assemblies, where reinforced to receive anchors, to verify that locations of concealed reinforcements are clearly marked for Installer. Locate reinforcements and mark locations if not already done.

3.2 INSTALLATION, GENERAL

- A. Fit exposed connections together to form tight, hairline joints.
- B. Perform cutting, drilling, and fitting required for installing railings. Set railings accurately in location, alignment, and elevation; measured from established lines and levels and free of rack.

1. Do not weld, cut, or abrade surfaces of railing components that are coated or finished after fabrication and that are intended for field connection by mechanical or other means without further cutting or fitting.
 2. Set posts plumb within a tolerance of 1/16 inch in 3 feet.
 3. Align rails so variations from level for horizontal members and variations from parallel with rake of steps and ramps for sloping members do not exceed 1/4 inch in 12 feet.
- C. Control of Corrosion: Prevent galvanic action and other forms of corrosion by insulating metals and other materials from direct contact with incompatible materials.
1. Coat, with a heavy coat of bituminous paint, concealed surfaces of aluminum that are in contact with grout, concrete, masonry, wood, or dissimilar metals.
- D. Adjust railings before anchoring to ensure matching alignment at abutting joints.
- E. Fastening to In-Place Construction: Use anchorage devices and fasteners where necessary for securing railings and for properly transferring loads to in-place construction.

3.3 RAILING CONNECTIONS

- A. Nonwelded Connections: Use mechanical or adhesive joints for permanently connecting railing components. Seal recessed holes of exposed locking screws using plastic cement filler colored to match finish of railings.
- B. Welded Connections: Use fully welded joints for permanently connecting railing components. Comply with requirements for welded connections in "Fabrication" Article whether welding is performed in the shop or in the field.

3.4 ANCHORING POSTS

- A. Use metal sleeves preset and anchored into concrete for installing posts. After posts are inserted into sleeves, fill annular space between post and sleeve with nonshrink, nonmetallic grout or anchoring cement, mixed and placed to comply with anchoring material manufacturer's written instructions.
- B. Cover anchorage joint with flange of same metal as post, [welded to post after placing anchoring material] [attached to post with set screws].
- C. Leave anchorage joint exposed with [1/8-inch buildup, sloped away from post] [anchoring material flush with adjacent surface].

3.5 ATTACHING RAILINGS

- A. Anchor railing ends at walls with round flanges anchored to wall construction and welded to railing ends.
- B. Anchor railing ends to metal surfaces with flanges bolted to metal surfaces and welded to railing ends.
- C. Secure wall brackets and railing end flanges to building construction as follows:
1. For concrete and solid masonry anchorage, use drilled-in expansion shields and hanger or lag bolts.
 2. For steel-framed partitions, use self-tapping screws fastened to steel framing or to concealed steel reinforcements.

3.6 ADJUSTING AND CLEANING

- A. Clean stainless steel by washing thoroughly with clean water and soap and rinsing with clean water.

- B. Touchup Painting: Immediately after erection, clean field welds, bolted connections, and abraded areas of shop paint, and paint exposed areas with the same material as used for shop painting to comply with SSPC-PA 1 requirements for touching up shop-painted surfaces.
 - 1. Apply by brush or spray to provide a minimum 2.0-mil dry film thickness.
- C. Touchup Painting: Cleaning and touchup painting of field welds, bolted connections, and abraded areas of shop paint are specified in [Section 099113 "Exterior Painting" and Section 099123 "Interior Painting."] [Section 099600 "High-Performance Coatings."] [Section 099113 "Exterior Painting," Section 099123 "Interior Painting," and Section 099600 "High-Performance Coatings."]
- D. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas, and repair galvanizing to comply with ASTM A 780/A 780M.

3.7 PROTECTION

- A. Protect finishes of railings from damage during construction period with temporary protective coverings approved by railing manufacturer. Remove protective coverings at time of Substantial Completion.

END OF SECTION 055213

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SECTION 057300

DECORATIVE METAL RAILINGS

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section Includes:
 - 1. Stainless-steel decorative railings[with stainless-steel wire-rope guard infill].
 - 2. Illuminated decorative railings.

1.3 DEFINITIONS

- A. Railings: Guards, handrails, and similar devices used for protection of occupants at open-sided floor areas and for pedestrian guidance and support, visual separation, or wall protection.

1.4 COORDINATION AND SCHEDULING

- A. Coordinate selection of shop primers with topcoats to be applied over them. Comply with paint and coating manufacturers' written instructions to ensure that shop primers and topcoats are compatible.
- B. Coordinate installation of anchorages for railings. Furnish setting drawings, templates, and directions for installing anchorages, including sleeves, concrete inserts, anchor bolts, and items with integral anchors, that are to be embedded in concrete or masonry. Deliver items to Project site in time for installation.
- C. Schedule installation so wall attachments are made only to completed walls. Do not support railings temporarily by any means that do not meet structural performance requirements.

1.5 PREINSTALLATION MEETINGS

- A. Preinstallation Conference: Conduct conference at [Project site] <Insert location>.

1.6 ACTION SUBMITTALS

- A. Product Data: For the following:
 - 1. Manufacturer's product lines of railings assembled from standard components.
- B. Shop Drawings: Include plans, elevations, sections, and attachment details.
 - 1. For illuminated railings, include wiring diagrams and roughing-in details.
- C. Samples for Verification: For each type of exposed finish required.
 - 1. Sections of each distinctly different linear railing member, including handrails, top rails, posts, and balusters.
 - 2. Fittings and brackets.
 - 3. Welded connections.
 - 4. Assembled Samples of railing systems, made from full-size components, including top rail, post, handrail, and infill. Show method of finishing members at intersections. Samples need not be full height.

1.7 INFORMATIONAL SUBMITTALS

- A. Mill Certificates: Signed by manufacturers of stainless-steel products certifying that products furnished comply with requirements.
- B. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency, according to ASTM E 894 and ASTM E 935.
- C. Evaluation Reports: For post-installed anchors, from ICC-ES.

1.8 QUALITY ASSURANCE

- A. Mockups: Build mockups to verify selections made under Sample submittals, to demonstrate aesthetic effects, and to set quality standards for fabrication and installation.
 - 1. Build mockups as shown on Drawings.
 - 2. Build mockups for each form and finish of railing consisting of two posts, top rail, infill area, and anchorage system components that are full height and are not less than 24 inches in length.
 - 3. Subject to compliance with requirements, approved mockups may become part of the completed Work if undisturbed at time of Substantial Completion.

1.9 PRECONSTRUCTION TESTING

- A. Preconstruction Testing Service: a qualified testing agency to perform preconstruction testing on laboratory mockups. Payment for these services will be made [by Owner] [from the testing and inspecting allowance, as authorized by Change Orders] [by Contractor]. Retesting of products that fail to meet specified requirements shall be done at Contractor's expense.
 - 1. Build laboratory mockups at testing agency facility; use personnel, materials, and methods of construction that will be used at Project site.
 - 2. Test railings according to ASTM E 894 and ASTM E 935.
 - 3. Notify Architect [seven] <Insert number> days in advance of the dates and times when laboratory mockups will be tested.

1.10 FIELD CONDITIONS

- A. Field Measurements: Verify actual locations of walls and other construction contiguous with railings by field measurements before fabrication and indicate measurements on Shop Drawings.

PART 2 - PRODUCTS**2.1 MANUFACTURERS**

- A. Stainless-Steel Decorative Railings:
 - 1. Manufacturers: Subject to compliance with requirements, [provide products by the following] [provide products by one of the following] [available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following]:
 - 2. Basis-of-Design Product: Subject to compliance with requirements, provide [product indicated on Drawings] <Insert manufacturer's name; product name or designation> or comparable product by one of the following:
 - a. Architectural Metal Works.
 - b. Blum, Julius & Co., Inc.
 - c. Livers Bronze Co.
 - d. R & B Wagner, Inc.
- B. Illuminated Decorative Railings:

1. Manufacturers: Subject to compliance with requirements, [provide products by the following] [provide products by one of the following] [available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following]:
 2. Basis-of-Design Product: Subject to compliance with requirements, provide [product indicated on Drawings] <Insert manufacturer's name; product name or designation> or comparable product by one of the following:
 - a. C. W. Cole & Company, Inc.
- C. Source Limitations: Obtain each type of railing from single source from single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for system's aesthetic effects and performance characteristics. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction. Performance characteristics are indicated by criteria subject to verification by one or more methods, including structural analysis, preconstruction testing, field testing, and in-service performance.
1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Product Options: Drawings indicate size, profiles, and dimensional requirements of railings and are based on the specific system indicated. See Section 016000 "Product Requirements."
1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.

2.2 PERFORMANCE REQUIREMENTS

- A. Delegated Design: Engage a qualified professional engineer, as defined in Section 014000 "Quality Requirements," to design railings, including attachment to building construction.
- B. General: In engineering railings to withstand structural loads indicated, determine allowable design working stresses of railing materials based on the following:
1. Stainless Steel: 60 percent of minimum yield strength.
- C. Structural Performance: Railings, including attachment to building construction, shall withstand the effects of gravity loads and the following loads and stresses within limits and under conditions indicated:
1. Handrails and Top Rails of Guards:
 - a. Uniform load of 50 lbf/ft. applied in any direction.
 - b. Concentrated load of 200 lbf applied in any direction.
 - c. Uniform and concentrated loads need not be assumed to act concurrently.
 2. Infill of Guards:
 - a. Concentrated load of 50 lbf applied horizontally on an area of 1 sq. ft..
 - b. Infill load and other loads need not be assumed to act concurrently.
- D. Thermal Movements: Allow for thermal movements from ambient and surface temperature changes acting on exterior railings by preventing buckling, opening of joints, overstressing of components, failure of connections, and other detrimental effects.
1. Temperature Change: 120 deg F, ambient; 180 deg F, material surfaces.

2.3 METALS, GENERAL

- A. Metal Surfaces, General: Provide materials with smooth surfaces, without seam marks, roller marks, rolled trade names, stains, discolorations, or blemishes.

- B. Brackets, Flanges, and Anchors: Same metal and finish as supported rails unless otherwise indicated.
 - 1. Provide cast-metal brackets with flange tapped for concealed anchorage to threaded hanger bolt.
 - 2. Provide either formed- or cast-metal brackets with predrilled hole for exposed bolt anchorage.
 - 3. Provide formed-steel brackets with predrilled hole for bolted anchorage and with snap-on cover that matches rail finish and conceals bracket base and bolt head.
 - 4. Provide extruded-aluminum brackets with interlocking pieces that conceal anchorage. Locate set screws on bottom of bracket.

2.4 STAINLESS STEEL

- A. Tubing: ASTM A 554, Grade MT 304 Grade MT 316 Grade MT 316L.

2.5 FASTENERS

- A. Fastener Materials: Unless otherwise indicated, provide the following:
 - 1. Stainless-Steel Components: [Type 304] [Type 316] stainless-steel fasteners.
 - 2. Dissimilar Metals: [Type 304] [Type 316] stainless-steel fasteners.
- B. Fasteners for Anchoring to Other Construction: Select fasteners of type, grade, and class required to produce connections suitable for anchoring railings to other types of construction indicated.
- C. Provide concealed fasteners for interconnecting railing components and for attaching railings to other work unless [otherwise indicated] [exposed fasteners are unavoidable] [exposed fasteners are the standard fastening method for railings indicated].
 - 1. Provide [Phillips] [tamper-resistant] [square or hex socket] flat-head machine screws for exposed fasteners unless otherwise indicated.
- D. Post-Installed Anchors: Fastener systems with working capacity greater than or equal to the design load, according to an evaluation report acceptable to authorities having jurisdiction, based on ICC-ES AC193[or ICC-ES AC308].
 - 1. Material for Interior Locations: Carbon-steel components zinc plated to comply with ASTM B 633 or ASTM F 1941, Class Fe/Zn 5, unless otherwise indicated.
 - 2. Material for Exterior Locations and Where Stainless Steel Is Indicated: Alloy [Group 1] [Group 2] stainless-steel bolts, ASTM F 593, and nuts, ASTM F 594.

2.6 MISCELLANEOUS MATERIALS

- A. Electrical Components: Provide internal, fluorescent light fixtures and electrical components, required as part of illuminated railings, that comply with NFPA 70, are listed and labeled by a qualified testing agency as defined in NFPA 70, and are marked for intended location and application.
- B. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.
- C. Intermediate Coats and Topcoats: Provide products that comply with
- D. Nonshrink, Nonmetallic Grout: Factory-packaged, nonstaining, noncorrosive, nongaseous grout complying with ASTM C 1107/C 1107M. Provide grout specifically recommended by manufacturer for interior and exterior applications.

2.7 FABRICATION

- A. General: Fabricate railings to comply with requirements indicated for design, dimensions, member sizes and spacing, details, finish, and anchorage.
- B. Assemble railings in the shop to greatest extent possible to minimize field splicing and assembly. Disassemble units only as necessary for shipping and handling limitations. Clearly mark units for reassembly and coordinated installation. Use connections that maintain structural value of joined pieces.
- C. Cut, drill, and punch metals cleanly and accurately. Remove burrs and ease edges to a radius of approximately 1/32 inch unless otherwise indicated. Remove sharp or rough areas on exposed surfaces.
- D. Form work true to line and level with accurate angles and surfaces.
- E. Fabricate connections that will be exposed to weather in a manner to exclude water. Provide weep holes where water may accumulate. Locate weep holes in inconspicuous locations.
- F. Cut, reinforce, drill, and tap as indicated to receive finish hardware, screws, and similar items.
- G. Connections: Fabricate railings with welded connections unless otherwise indicated.
- H. Welded Connections: Cope components at connections to provide close fit, or use fittings designed for this purpose. Weld all around at connections, including at fittings.
 - 1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
 - 2. Obtain fusion without undercut or overlap.
 - 3. Remove flux immediately.
 - 4. At exposed connections, finish exposed welds to comply with NOMMA's "Voluntary Joint Finish Standards" for Type 1 welds; no evidence of a welded joint.
- I. Welded Connections for Aluminum Pipe: Fabricate railings to interconnect members with concealed internal welds that eliminate surface grinding, using manufacturer's standard system of sleeve and socket fittings.
- J. Mechanical Connections: Connect members with concealed mechanical fasteners and fittings. Fabricate members and fittings to produce flush, smooth, rigid, hairline joints.
 - 1. Fabricate splice joints for field connection using an epoxy structural adhesive if this is manufacturer's standard splicing method.
- K. Form changes in direction as follows:
 - 1. By bending.
 - 2. By flush bends.
- L. Bend members in jigs to produce uniform curvature for each configuration required; maintain cross section of member throughout entire bend without buckling, twisting, cracking, or otherwise deforming exposed surfaces of components.
- M. Close exposed ends of hollow railing members with prefabricated end fittings.
- N. Provide wall returns at ends of wall-mounted handrails unless otherwise indicated. Close ends of returns, unless clearance between end of rail and wall is 1/4 inch or less.
- O. Brackets, Flanges, Fittings, and Anchors: Provide wall brackets, flanges, miscellaneous fittings, and anchors to interconnect railing members to other work unless otherwise indicated.

1. At brackets and fittings fastened to plaster or gypsum board partitions, provide crush-resistant fillers, or other means to transfer loads through wall finishes to structural supports and to prevent bracket or fitting rotation and crushing of substrate.
- P. Provide inserts and other anchorage devices for connecting railings to concrete or masonry work. Fabricate anchorage devices capable of withstanding loads imposed by railings. Coordinate anchorage devices with supporting structure.
- Q. For railing posts set in concrete, provide [steel] [stainless-steel] sleeves not less than 6 inches long with inside dimensions not less than 1/2 inch greater than outside dimensions of post, with metal plate forming bottom closure.

2.8 ILLUMINATED RAILINGS

- A. Illuminated Units: Provide internal illumination using concealed, internally wired fluorescent-strip fixture system to illuminate walking surfaces adjacent to railings without light leaks. Make provisions for servicing and for concealed connection to electric service. Coordinate electrical characteristics with those of the power supply provided.
 1. Fluorescent Tubes: Provide number of tubes indicated or required by railing length.
 2. Diffusers: UV-stabilized acrylic diffusers matching profile of railings.
 3. Ballasts: Energy-saving, high power factor, Class P, electromagnetic type; designed for use with high-output lamps and with automatic-reset thermal protection. Ballasts comply with ANSI C82.1, bear Certified Ballast Manufacturer Certification labels, and are rated for [zero deg F] [minus 20 deg F] starting temperature.

2.9 GENERAL FINISH REQUIREMENTS

- A. Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" recommendations for applying and designating finishes.
- B. Protect mechanical finishes on exposed surfaces from damage by applying a strippable, temporary protective covering before shipment.
- C. Provide exposed fasteners with finish matching appearance, including color and texture, of railings.

2.10 STAINLESS-STEEL FINISHES

- A. Surface Preparation: Remove tool and die marks and stretch lines, or blend into finish.
- B. Polished Finishes: Grind and polish surfaces to produce uniform finish, free of cross scratches.
 1. Run grain of directional finishes with long dimension of each piece.
- C. Directional Satin Finish: No. 4.
- D. When polishing is completed, passivate and rinse surfaces. Remove embedded foreign matter and leave surfaces chemically clean.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine plaster and gypsum board assemblies, where reinforced to receive anchors, to verify that locations of concealed reinforcements have been clearly marked for Installer. Locate reinforcements and mark locations if not already done.

3.2 INSTALLATION, GENERAL

- A. Fit exposed connections together to form tight, hairline joints.

- B. Perform cutting, drilling, and fitting required for installing railings. Set railings accurately in location, alignment, and elevation; measured from established lines and levels and free of rack.
 - 1. Do not weld, cut, or abrade surfaces of railing components that have been coated or finished after fabrication and that are intended for field connection by mechanical or other means without further cutting or fitting.
 - 2. Set posts plumb within a tolerance of 1/16 inch in 3 feet.
 - 3. Align rails so variations from level for horizontal members and variations from parallel with rake of steps and ramps for sloping members do not exceed 1/4 inch in 12 feet.
- C. Adjust railings before anchoring to ensure matching alignment at abutting joints.
- D. Fastening to In-Place Construction: Use anchorage devices and fasteners where necessary for securing railings and for properly transferring loads to in-place construction.

3.3 RAILING CONNECTIONS

- A. Welded Connections: Use fully welded joints for permanently connecting railing components. Comply with requirements for welded connections in "Fabrication" Article whether welding is performed in the shop or in the field.
- B. Expansion Joints: Install expansion joints at locations indicated but not farther apart than required to accommodate thermal movement. Provide slip-joint internal sleeve extending 2 inches beyond joint on either side, fasten internal sleeve securely to one side, and locate joint within 6 inches of post.

3.4 ANCHORING POSTS

- A. Use steel pipe sleeves preset and anchored into concrete for installing posts. After posts have been inserted into sleeves, fill annular space between post and sleeve with [nonshrink, nonmetallic grout] [or] [anchoring cement], mixed and placed to comply with anchoring material manufacturer's written instructions.
- B. Cover anchorage joint with flange of same metal as post, welded to post after placing anchoring material.
- C. Leave anchorage joint exposed with [1/8-inch buildup, sloped away from post] [anchoring material flush with adjacent surface].

3.5 ATTACHING RAILINGS

- A. Anchor railing ends to metal surfaces with flanges bolted to metal surfaces and welded to railing ends.
- B. Attach handrails to walls with wall brackets[except where end flanges are used]. Provide brackets with 1-1/2-inch clearance from inside face of handrail and finished wall surface. Locate brackets as indicated or, if not indicated, at spacing required to support structural loads.
 - 1. Use type of bracket with [flange tapped for concealed anchorage to threaded hanger bolt] [predrilled hole for exposed bolt anchorage].
 - 2. Locate brackets as indicated or, if not indicated, at spacing required to support structural loads.
- C. Secure wall brackets[and railing end flanges] to building construction as follows:
 - 1. For concrete and solid masonry anchorage, use drilled-in expansion shields and hanger or lag bolts.
 - 2. For steel-framed partitions, fasten brackets directly to steel framing or concealed steel reinforcements using self-tapping screws of size and type required to support structural loads.

3.6 FIELD QUALITY CONTROL

- A. Extent and Testing Methodology: Testing agency will randomly select completed railing assemblies for testing that are representative of different railing designs and conditions in the completed Work. Test railings according to ASTM E 894 and ASTM E 935 for compliance with performance requirements.
- B. Remove and replace railings where test results indicate that they do not comply with specified requirements unless they can be repaired in a manner satisfactory to Architect and comply with specified requirements.
- C. Perform additional testing and inspecting, at Contractor's expense, to determine compliance of replaced or additional work with specified requirements.

3.7 CLEANING

- A. Clean aluminum and stainless steel by washing thoroughly with clean water and soap, rinsing with clean water, and wiping dry.
- B. Clean and polish [glass] [and] [plastic glazing] as recommended in writing by manufacturer. Wash both exposed surfaces in each area of Project not more than four days before date scheduled for inspections that establish date of Substantial Completion.
- C. Clean by wiping with a damp cloth and then wiping dry.
- D. Touchup Painting: Immediately after erection, clean field welds, bolted connections, and abraded areas of shop paint, and paint exposed areas with the same material used for shop painting to comply with SSPC-PA 1 for touching up shop-painted surfaces.
 - 1. Apply by brush or spray to provide a minimum 2.0-mil dry film thickness.
- E. Touchup Painting: Cleaning and touchup painting of field welds, bolted connections, and abraded areas of shop paint are specified in [Section 099113 "Exterior Painting" and Section 099123 "Interior Painting."] [Section 099600 "High-Performance Coatings."] [Section 099113 "Exterior Painting," Section 099123 "Interior Painting," and Section 099600 "High-Performance Coatings."]

3.8 PROTECTION

- A. Protect finishes of railings from damage during construction period with temporary protective coverings approved by railing manufacturer. Remove protective coverings at time of Substantial Completion.
- B. Restore finishes damaged during installation and construction period so no evidence remains of correction work. Return items that cannot be refinished in the field to the shop; make required alterations and refinish entire unit, or provide new units.

END OF SECTION 057300

SECTION 057313

GLAZED DECORATIVE METAL RAILINGS

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section Includes:
 - 1. Glass- and plastic-supported railings.

1.3 DEFINITIONS

- A. Railings: Guards, handrails, and similar devices used for protection of occupants at open-sided floor areas and for pedestrian guidance and support, visual separation, or wall protection.

1.4 COORDINATION AND SCHEDULING

- A. Coordinate selection of shop primers with topcoats to be applied over them. Comply with paint and coating manufacturers' written instructions to ensure that shop primers and topcoats are compatible.
- B. Coordinate installation of anchorages for railings. Furnish setting drawings, templates, and directions for installing anchorages, including sleeves, concrete inserts, anchor bolts, and items with integral anchors, that are to be embedded in concrete or masonry. Deliver items to Project site in time for installation.

1.5 PREINSTALLATION MEETINGS

- A. Preinstallation Conference: Conduct conference at [Project site] <Insert location>.

1.6 ACTION SUBMITTALS

- A. Product Data: For the following:
 - 1. Manufacturer's product lines of railings assembled from standard components.
 - 2. Grout, anchoring cement, and paint products.
- B. Shop Drawings: Include plans, elevations, sections, and attachment details.
- C. Samples for Initial Selection: For products involving selection of color, texture, or design[, including mechanical finishes].
- D. Delegated-Design Submittal: For installed products indicated to comply with performance requirements and design criteria, including analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

1.7 INFORMATIONAL SUBMITTALS

- A. Qualification Data: For [professional engineer] [testing agency].
- B. Mill Certificates: Signed by manufacturers of stainless-steel products certifying that products furnished comply with requirements.

- C. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency, according to ASTM E 894 and ASTM E 935.
- D. Preconstruction test reports.
- E. Evaluation Reports: For post-installed anchors, from ICC-ES.

1.8 QUALITY ASSURANCE

- A. Mockups: Build mockups to verify selections made under Sample submittals, to demonstrate aesthetic effects, and to set quality standards for fabrication and installation.
 - 1. Build mockups as shown on Drawings.
 - 2. Build mockups for each form and finish of railing consisting of two posts, top rail, infill area, and anchorage system components that are full height and are not less than 24 inches in length.
 - 3. Subject to compliance with requirements, approved mockups may become part of the completed Work if undisturbed at time of Substantial Completion.

1.9 PRECONSTRUCTION TESTING

- A. Preconstruction Testing Service: [Owner will engage] [Engage] a qualified testing agency to perform preconstruction testing on laboratory mockups. Payment for these services will be made [by Owner] [from the testing and inspecting allowance, as authorized by Change Orders] [by Contractor]. Retesting of products that fail to meet specified requirements shall be done at Contractor's expense.
 - 1. Build laboratory mockups at testing agency facility; use personnel, materials, and methods of construction that will be used at Project site.
 - 2. Test railings according to ASTM E 894 and ASTM E 935.
 - 3. Notify Architect [seven] <Insert number> days in advance of the dates and times when laboratory mockups will be tested.

1.10 FIELD CONDITIONS

- A. Field Measurements: Verify actual locations of walls and other construction contiguous with railings by field measurements before fabrication and indicate measurements on Shop Drawings.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Manufacturers: Subject to compliance with requirements, [provide products by the following] [provide products by one of the following] [available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following]:
- B. Basis-of-Design Product: Subject to compliance with requirements, provide [product indicated on Drawings] <Insert manufacturer's name; product name or designation> or comparable product by one of the following:
 - 1. Architectural Metal Works.
 - 2. Architectural Railings & Grilles, Inc.
 - 3. Julius Blum & Co., Inc.
 - 4. C. R. Laurence Co., Inc.
- C. Source Limitations: Obtain each type of railing from single source from single manufacturer.

- D. Product Options: Information on Drawings and in Specifications establishes requirements for system's aesthetic effects and performance characteristics. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction. Performance characteristics are indicated by criteria subject to verification by one or more methods, including structural analysis, preconstruction testing, field testing, and in-service performance.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Product Options: Drawings indicate size, profiles, and dimensional requirements of railings and are based on the specific system indicated. See Section 016000 "Product Requirements."
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.

2.2 PERFORMANCE REQUIREMENTS

- A. Delegated Design: Engage a qualified professional engineer, as defined in Section 014000 "Quality Requirements," to design railings, including attachment to building construction.
- B. General: In engineering railings to withstand structural loads indicated, determine allowable design working stresses of railing materials based on the following:
 - 1. Steel: 72 percent of minimum yield strength.
 - 2. Glass: 25 percent of mean modulus of rupture (50 percent probability of breakage), as listed in "Mechanical Properties" in AAMA's Aluminum Curtain Wall Series No. 12, "Structural Properties of Glass."
- C. Structural Performance: Railings, including attachment to building construction, shall withstand the effects of gravity loads and the following loads and stresses within limits and under conditions indicated:
 - 1. Handrails and Top Rails of Guards:
 - a. Uniform load of 50 lbf/ft. applied in any direction.
 - b. Concentrated load of 200 lbf applied in any direction.
 - c. Uniform and concentrated loads need not be assumed to act concurrently.
 - 2. Infill of Guards:
 - a. Concentrated load of 50 lbf applied horizontally on an area of 1 sq. ft..
 - b. Infill load and other loads need not be assumed to act concurrently.
 - 3. Glass-Supported Railings: Support each section of top rail by a minimum of three glass panels or by other means so top rail will remain in place if any one panel fails.
- D. Thermal Movements: Allow for thermal movements from ambient and surface temperature changes acting on exterior railings by preventing buckling, opening of joints, overstressing of components, failure of connections, and other detrimental effects.
 - 1. Temperature Change: 120 deg F, ambient; 180 deg F, material surfaces.

2.3 METALS, GENERAL

- A. Metal Surfaces, General: Provide materials with smooth surfaces, without seam marks, roller marks, rolled trade names, stains, discolorations, or blemishes.
- B. Brackets, Flanges, and Anchors: Same metal and finish as supported rails unless otherwise indicated.

2.4 GLASS AND GLAZING MATERIALS

- A. Safety Glazing: Glazing shall comply with 16 CFR 1201, Category II.

- B. Tempered Glass: ASTM C 1048, Kind FT (fully tempered), Condition A (uncoated), Type 1 (transparent flat glass), Quality-Q3. Provide products that have been tested for surface and edge compression according to ASTM C 1048 and for impact strength according to 16 CFR 1201 for Category II materials.
1. Glass Color: [Clear] [Blue] [Blue-green] [Bronze] [Green] [Gray] <Insert color>.
 2. Thickness for Structural Glass Balusters: [12.0] [19.0] mm.
 3. Thickness for Structural Glass Balusters: As required by structural loads, but not less than [12.0] [19.0] mm.
 4. Thickness: As indicated on Drawings.
- C. Laminated Glass: ASTM C 1172, Condition A (uncoated), Type I (transparent flat glass), Quality-Q3 with two plies of glass and polyvinyl butyral interlayer not less than 0.060 inch thick.
1. Basis-of-Design Product: Subject to compliance with requirements, provide <Insert manufacturer's name; product name or designation> or comparable product by one of the following:
 - a. <Insert, in separate subparagraphs, manufacturer's name>.
 2. Kind: LT (laminated tempered).
 3. Glass Color: [Clear] [Blue] [Blue-green] [Bronze] [Green] [Gray] <Insert color>.
 4. Interlayer Color: [Clear] [Blue-green] [Bronze light] [Gray] <Insert color>.
 5. Interlayer Color and Pattern: [As selected by Architect from manufacturer's full range] [Match] [Provide] <Insert manufacturer's color and pattern designation>.
 6. Glass Plies for Structural Glass Balusters: [6.0] [8.0] [10.0] mm thick each.
 7. Glass Plies for Structural Glass Balusters: Thickness required by structural loads, but not less than [6.0] [8.0] mm thick each.
- D. Ceramic-Coated Glass: Heat-treated float glass, Condition C; with ceramic enamel applied by silk-screened process; complying with Specification No. 95-1-31 in GANA's "Engineering Standards Manual" and with other requirements specified.
1. Basis-of-Design Product: Subject to compliance with requirements, provide <Insert manufacturer's name; product name or designation> or comparable product by one of the following:
 - a. <Insert, in separate subparagraphs, manufacturer's name>.
 2. Glass Color: [Clear] [Blue] [Blue-green] [Bronze] [Green] [Gray] <Insert color>.
 3. Ceramic Coating Color and Pattern: [As selected by Architect from manufacturer's full range] [Match] [Provide] <Insert manufacturer's color and pattern designation>.
- E. Safety Glazing Labeling: Permanently mark glass with certification label of [the SGCC] [the SGCC or another certification agency acceptable to authorities having jurisdiction] [or] [manufacturer]. Label shall indicate manufacturer's name, type of glass, thickness, and safety glazing standard with which glass complies.
- F. Glazing Cement and Accessories for Structural Glazing: Glazing cement, setting blocks, shims, and related accessories as recommended or supplied by railing manufacturer for installing structural glazing in metal subrails.
1. Glazing Cement: Nonshrinking organic cement designed for curing by passing an electric current through metal subrail holding glass panel, as standard with manufacturer.

2.5 FASTENERS

- A. Fastener Materials: Unless otherwise indicated, provide the following:
1. Dissimilar Metals: [Type 304] [Type 316] stainless-steel fasteners.
- B. Fasteners for Anchoring to Other Construction: Select fasteners of type, grade, and class required to produce connections suitable for anchoring railings to other types of construction indicated[and capable of withstanding design loads].

- C. Provide concealed fasteners for interconnecting railing components and for attaching railings to other work unless [otherwise indicated] [exposed fasteners are unavoidable] [exposed fasteners are the standard fastening method for railings indicated].
 - 1. Provide [Phillips] [tamper-resistant] [square or hex socket] flat-head machine screws for exposed fasteners unless otherwise indicated.
- D. Post-Installed Anchors: Fastener systems with working capacity greater than or equal to the design load, according to an evaluation report acceptable to authorities having jurisdiction, based on ICC-ES AC193[or ICC-ES AC308].
 - 1. Material for Interior Locations: Carbon-steel components zinc plated to comply with ASTM B 633 or ASTM F 1941, Class Fe/Zn 5, unless otherwise indicated.
 - 2. Material for Exterior Locations and Where Stainless Steel Is Indicated: Alloy [Group 1] [Group 2] stainless-steel bolts, ASTM F 593, and nuts, ASTM F 594.

2.6 MISCELLANEOUS MATERIALS

- A. Universal Shop Primer: Fast-curing, lead- and chromate-free, universal modified-alkyd primer complying with MPI#79.

2.7 FABRICATION

- A. General: Fabricate railings to comply with requirements indicated for design, dimensions, member sizes and spacing, details, finish, and anchorage[, but not less than that required to support structural loads].
- B. Assemble railings in the shop to greatest extent possible to minimize field splicing and assembly. Disassemble units only as necessary for shipping and handling limitations. Clearly mark units for reassembly and coordinated installation. Use connections that maintain structural value of joined pieces.
- C. Cut, drill, and punch metals cleanly and accurately. Remove burrs and ease edges to a radius of approximately 1/32 inch unless otherwise indicated. Remove sharp or rough areas on exposed surfaces.
- D. Form work true to line and level with accurate angles and surfaces.
- E. Fabricate connections that will be exposed to weather in a manner to exclude water. Provide weep holes where water may accumulate. Locate weep holes in inconspicuous locations.
- F. Cut, reinforce, drill, and tap as indicated to receive finish hardware, screws, and similar items.
- G. Mechanical Connections: Connect members with concealed mechanical fasteners and fittings. Fabricate members and fittings to produce flush, smooth, rigid, hairline joints.
 - 1. Fabricate splice joints for field connection using an epoxy structural adhesive if this is manufacturer's standard splicing method.
- H. Form changes in direction as follows:
 - 1. As detailed.
- I. Bend members in jigs to produce uniform curvature for each configuration required; maintain cross section of member throughout entire bend without buckling, twisting, cracking, or otherwise deforming exposed surfaces of components.
- J. Close exposed ends of hollow railing members with prefabricated end fittings.
- K. Brackets, Flanges, Fittings, and Anchors: Provide wall brackets, flanges, miscellaneous fittings, and anchors to interconnect railing members to other work where indicated.

1. At brackets and fittings fastened to plaster or gypsum board partitions, provide crush-resistant fillers, or other means to transfer loads through wall finishes to structural supports and to prevent bracket or fitting rotation and crushing of substrate.
- L. Provide inserts and other anchorage devices for connecting railings to concrete or masonry work. Fabricate anchorage devices capable of withstanding loads imposed by railings. Coordinate anchorage devices with supporting structure.

2.8 GLAZING PANEL FABRICATION

- A. General: Fabricate to sizes and shapes required; provide for proper edge clearance and bite on glazing panels.
 1. Clean-cut or flat-grind edges at butt-glazed sealant joints to produce square edges with slight chamfers at junctions of edges and faces.
 2. Grind smooth exposed edges, including those at open joints, to produce square edges with slight chamfers at junctions of edges and faces.
- B. Structural Glass Balusters: Factory-bond glass to aluminum base and top-rail channels in railing manufacturer's plant using glazing cement to comply with manufacturer's written specifications[, unless field glazing is standard with manufacturer].
- C. Structural Balusters: Provide laminated, tempered glass panels for both straight and curved sections.

2.9 GENERAL FINISH REQUIREMENTS

- A. Provide exposed fasteners with finish matching appearance, including color and texture, of railings.

PART 3 - EXECUTION

3.1 INSTALLATION, GENERAL

- A. Fit exposed connections together to form tight, hairline joints.
- B. Perform cutting, drilling, and fitting required for installing railings. Set railings accurately in location, alignment, and elevation; measured from established lines and levels and free of rack.
 1. Do not weld, cut, or abrade surfaces of railing components that have been coated or finished after fabrication and that are intended for field connection by mechanical or other means without further cutting or fitting.
 2. Set posts plumb within a tolerance of 1/16 inch in 3 feet.
 3. Align rails so variations from level for horizontal members and variations from parallel with rake of steps and ramps for sloping members do not exceed 1/4 inch in 12 feet.
- C. Control of Corrosion: Prevent galvanic action and other forms of corrosion by insulating metals and other materials from direct contact with incompatible materials.
- D. Adjust railings before anchoring to ensure matching alignment at abutting joints.
- E. Fastening to In-Place Construction: Use anchorage devices and fasteners where necessary for securing railings and for properly transferring loads to in-place construction.

3.2 ANCHORING POSTS

- A. Cover anchorage joint with flange of same metal as post, welded to post after placing anchoring material.
- B. Install removable railing sections, where indicated, in slip-fit metal sockets cast in concrete.

3.3 INSTALLING GLASS PANELS

- A. Glass-Supported Railings: Install assembly to comply with railing manufacturer's written instructions.
 - 1. Attach base channel to building structure, then insert and connect factory-fabricated and -assembled glass panels[if glass was bonded to base and top-rail channels in factory].
 - 2. Attach base channel to building structure, then insert glass into base channel and bond with glazing cement[unless glass was bonded to base and top-rail channels in factory].
 - a. Support glass panels in base channel at quarter points with channel-shaped setting blocks that also act as shims to maintain uniform space for glazing cement. Fill remaining space in base channel with glazing cement for uniform support of glass.
 - 3. Adjust spacing of glass panels so gaps between panels are equal before securing in position.
 - 4. Erect glass railings under direct supervision of manufacturer's authorized technical personnel.

3.4 FIELD QUALITY CONTROL

- A. Testing Agency: Owner will engage a qualified testing agency to perform tests and inspections and to prepare test reports. Payment for these services will be made [by Owner] [from the testing and inspecting allowance, as authorized by Change Orders].
- B. Extent and Testing Methodology: Testing agency will randomly select completed railing assemblies for testing that are representative of different railing designs and conditions in the completed Work. Test railings according to ASTM E 894 and ASTM E 935 for compliance with performance requirements.
- C. Remove and replace railings where test results indicate that they do not comply with specified requirements unless they can be repaired in a manner satisfactory to Architect and comply with specified requirements.
- D. Perform additional testing and inspecting, at Contractor's expense, to determine compliance of replaced or additional work with specified requirements.

3.5 CLEANING

- A. Clean and polish as recommended in writing by manufacturer. Wash both exposed surfaces in each area of Project not more than four days before date scheduled for inspections that establish date of Substantial Completion.

3.6 PROTECTION

- A. Protect finishes of railings from damage during construction period with temporary protective coverings approved by railing manufacturer. Remove protective coverings at time of Substantial Completion.
- B. Restore finishes damaged during installation and construction period so no evidence remains of correction work. Return items that cannot be refinished in the field to the shop; make required alterations and refinish entire unit, or provide new units.

END OF SECTION 057313

FEBRUARY 12, 2016

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GLAZED DECORATIVE METAL RAILINGS

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